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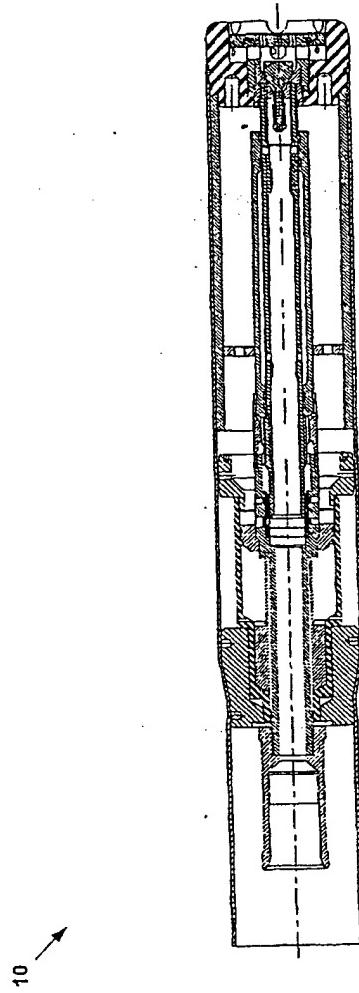
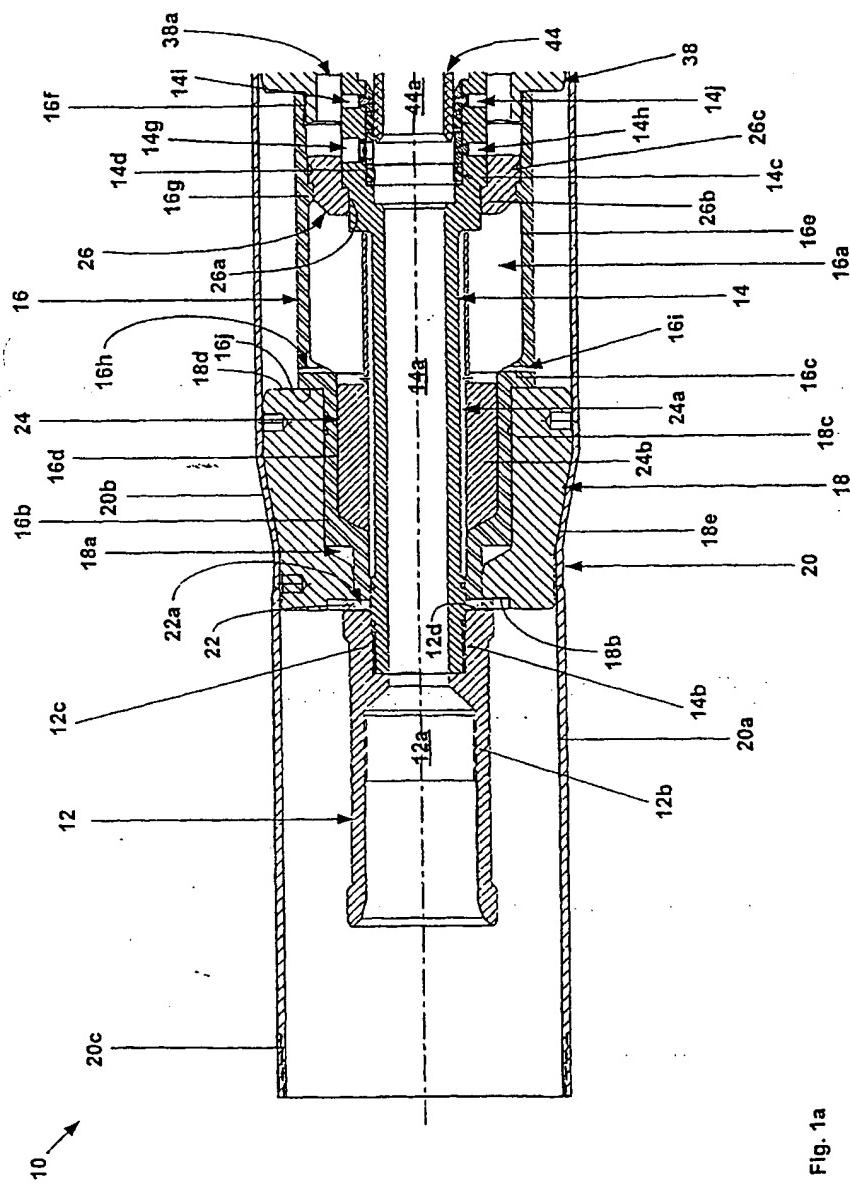
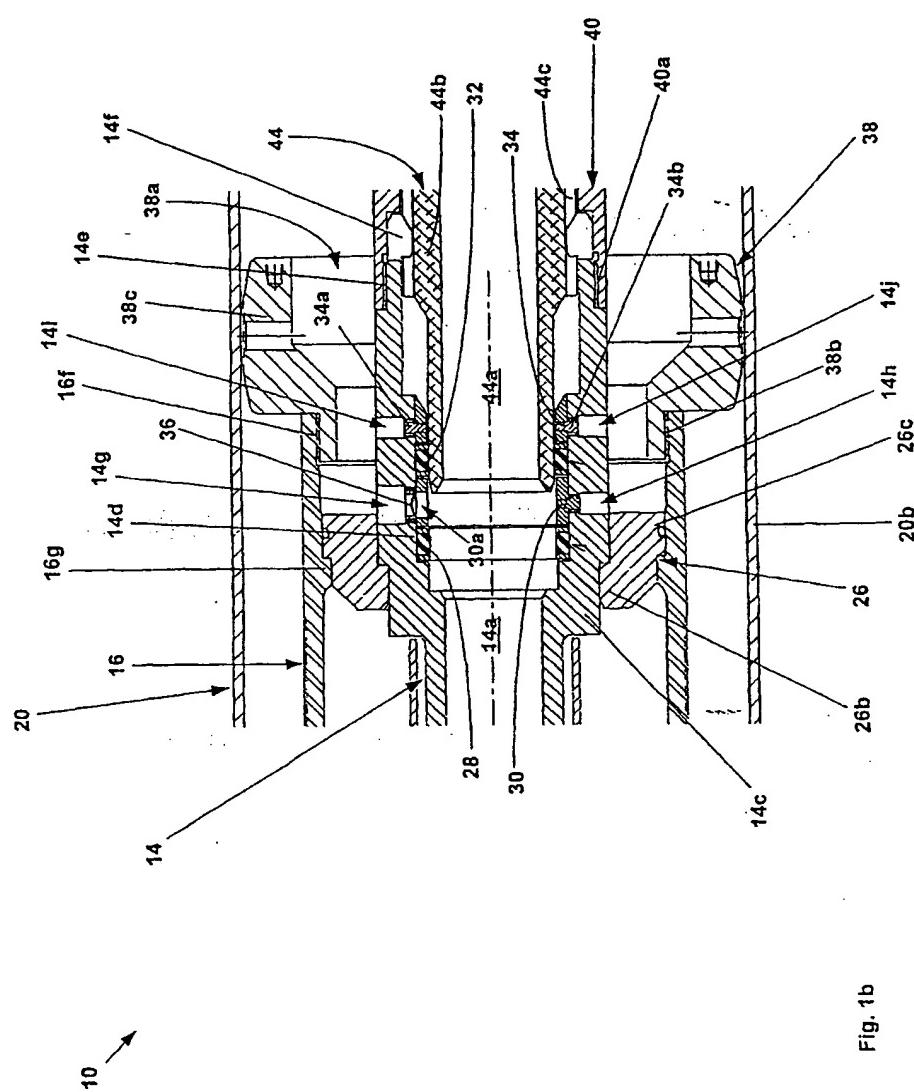


Fig. 1





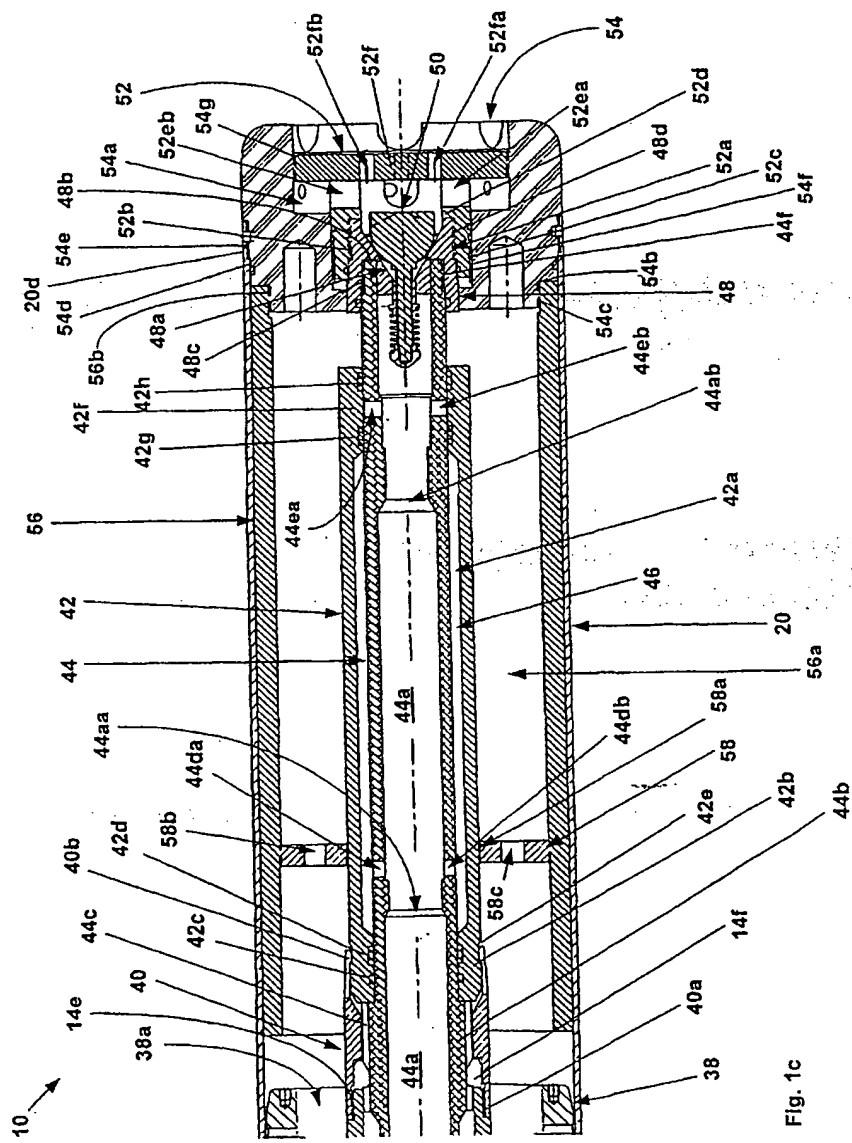


Fig. 1c

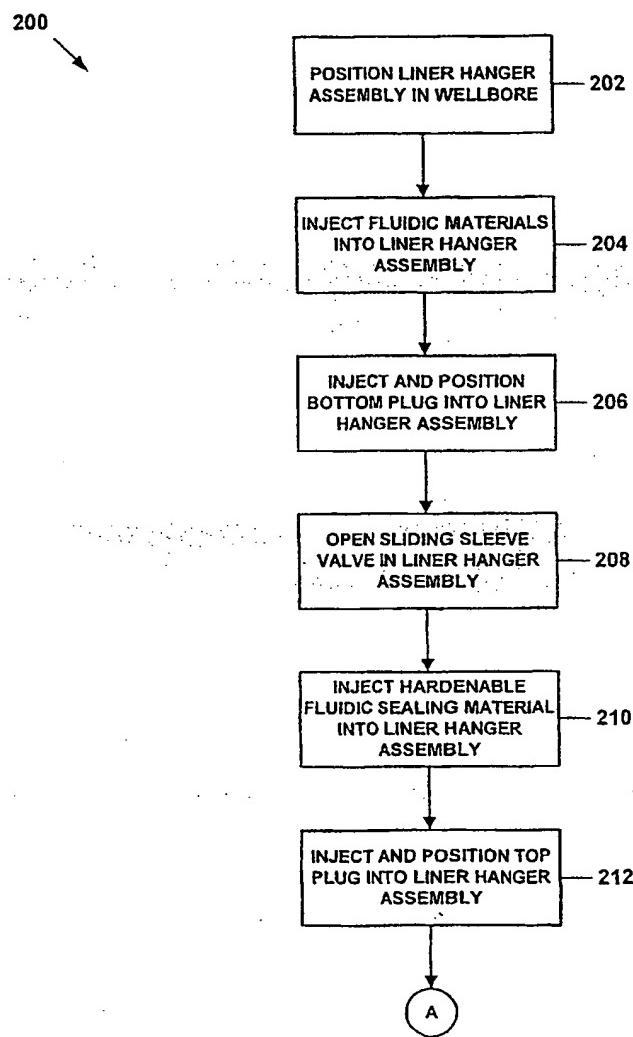


Fig. 2a

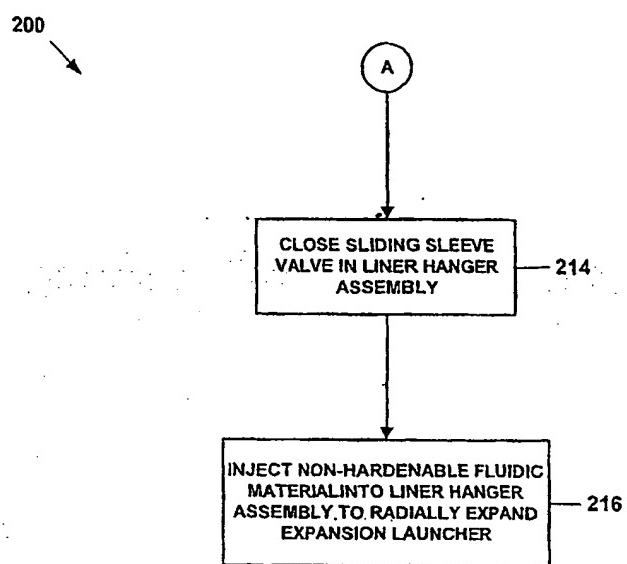


Fig. 2b

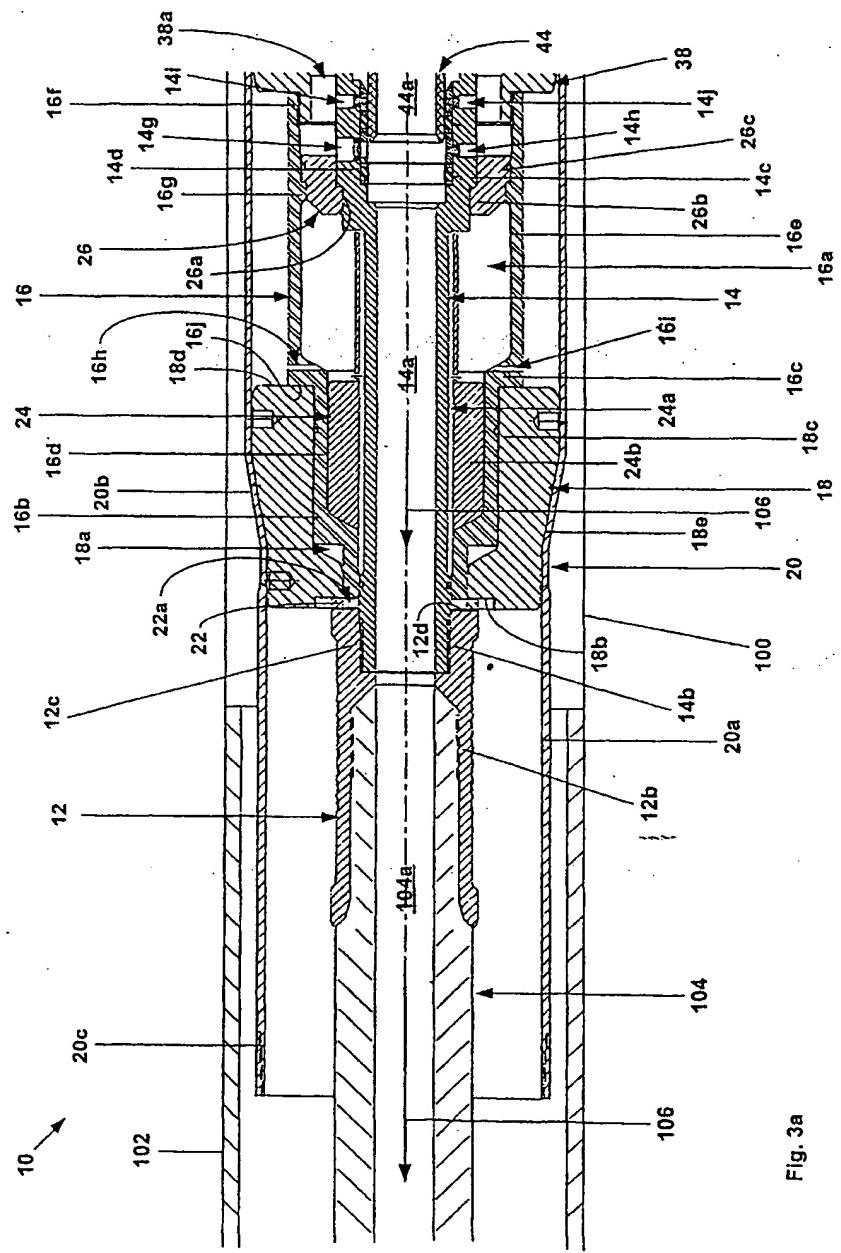


Fig. 3a

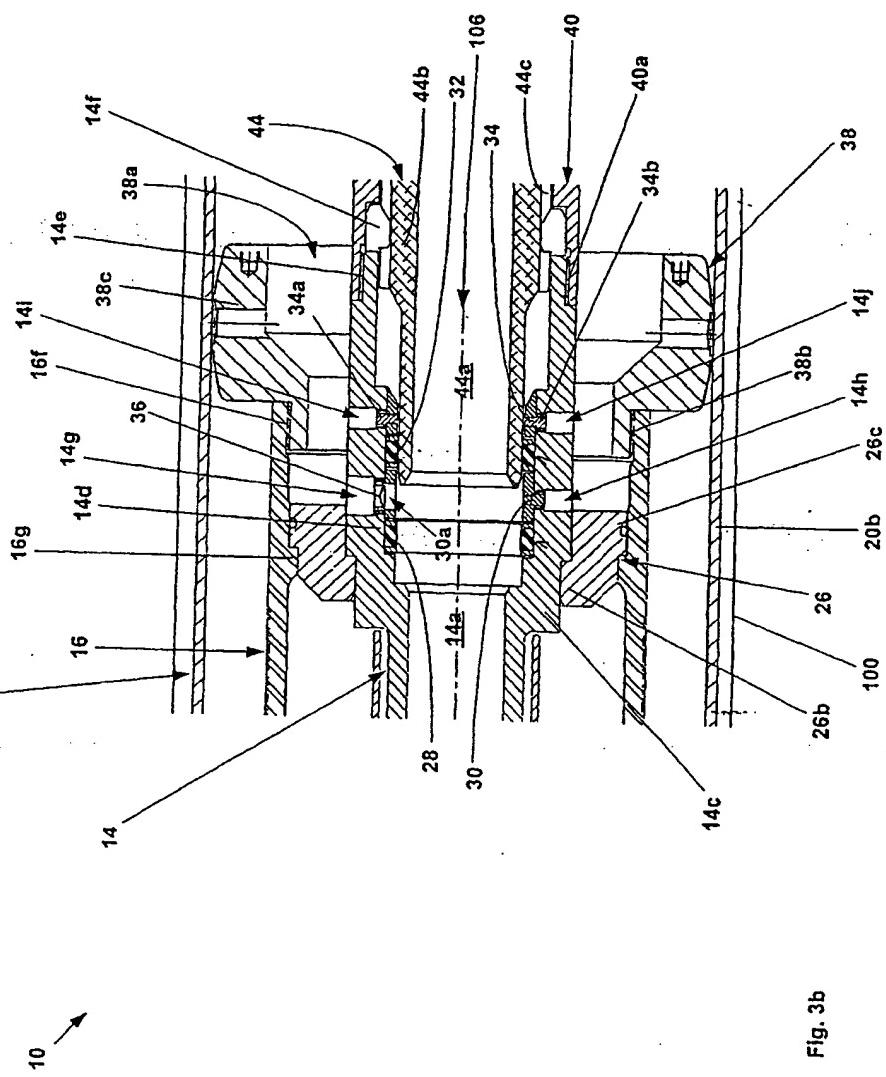
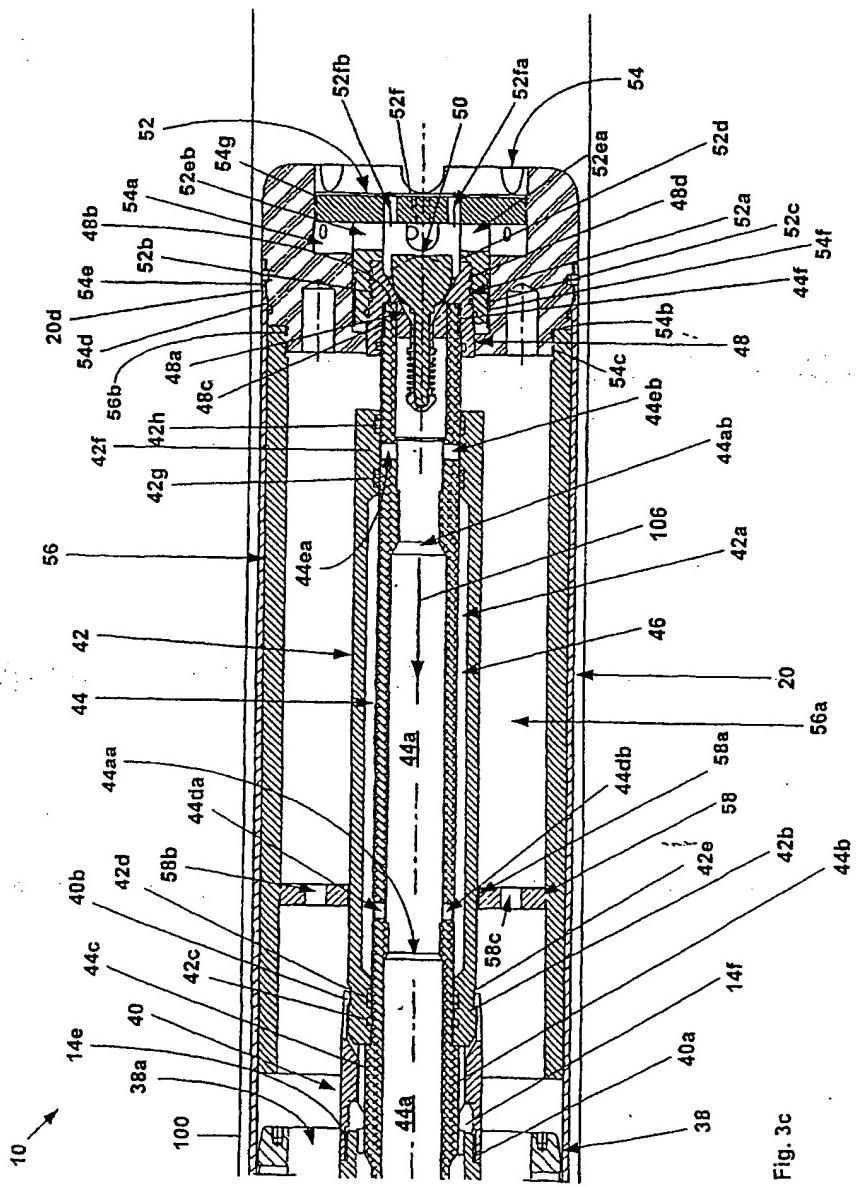


Fig. 3b



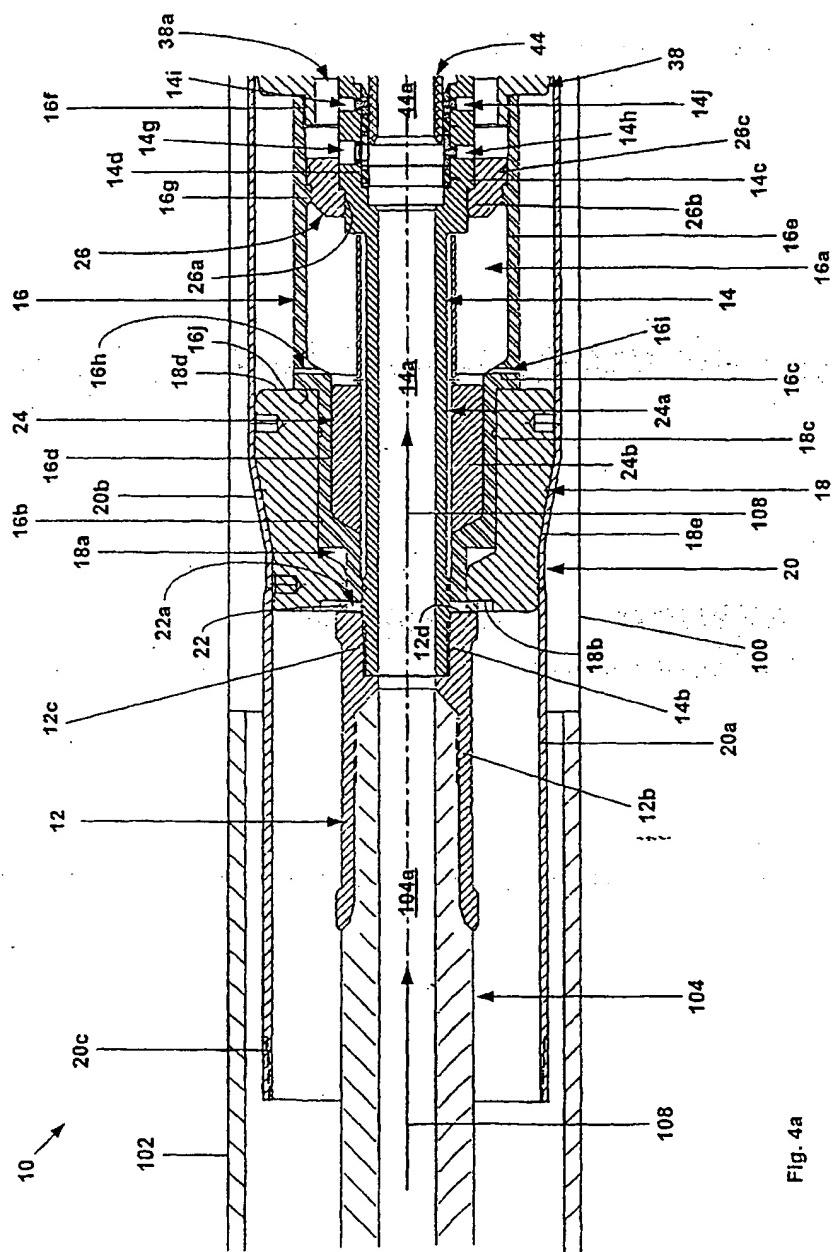


Fig. 4a

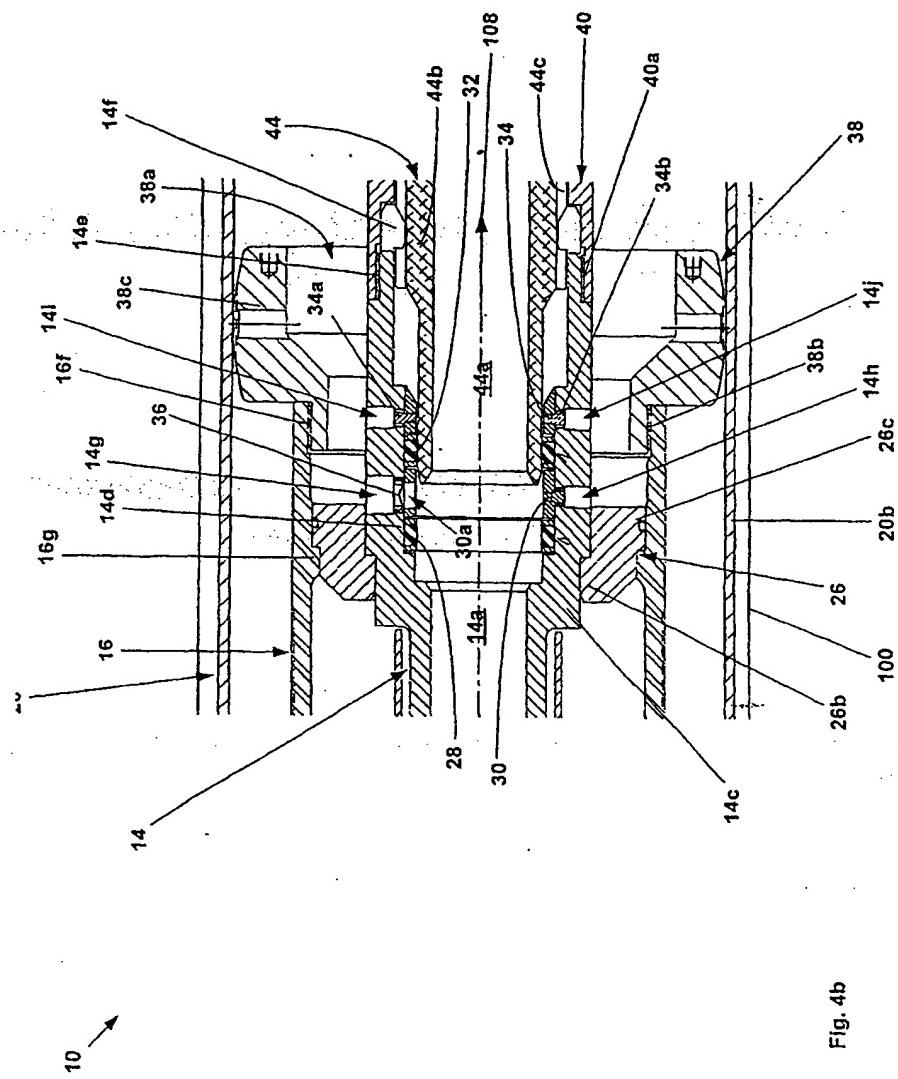
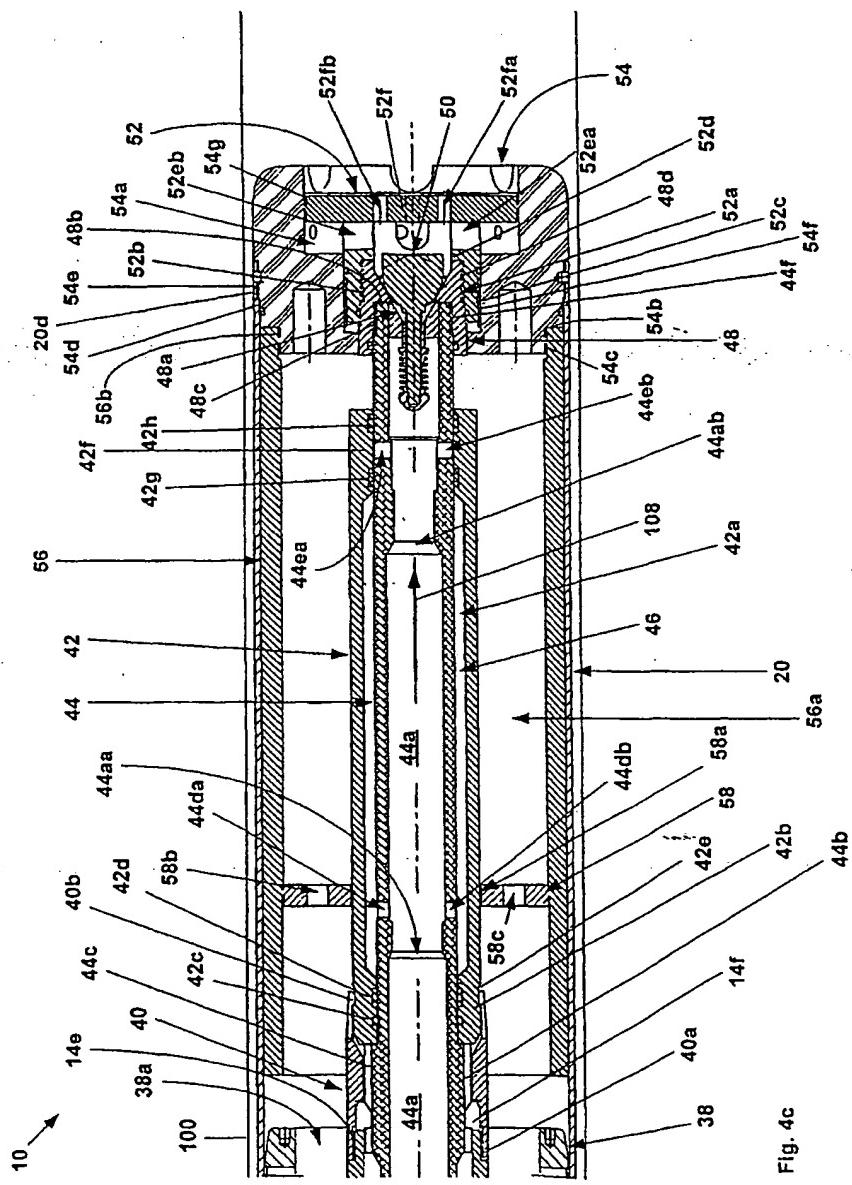


Fig. 4b



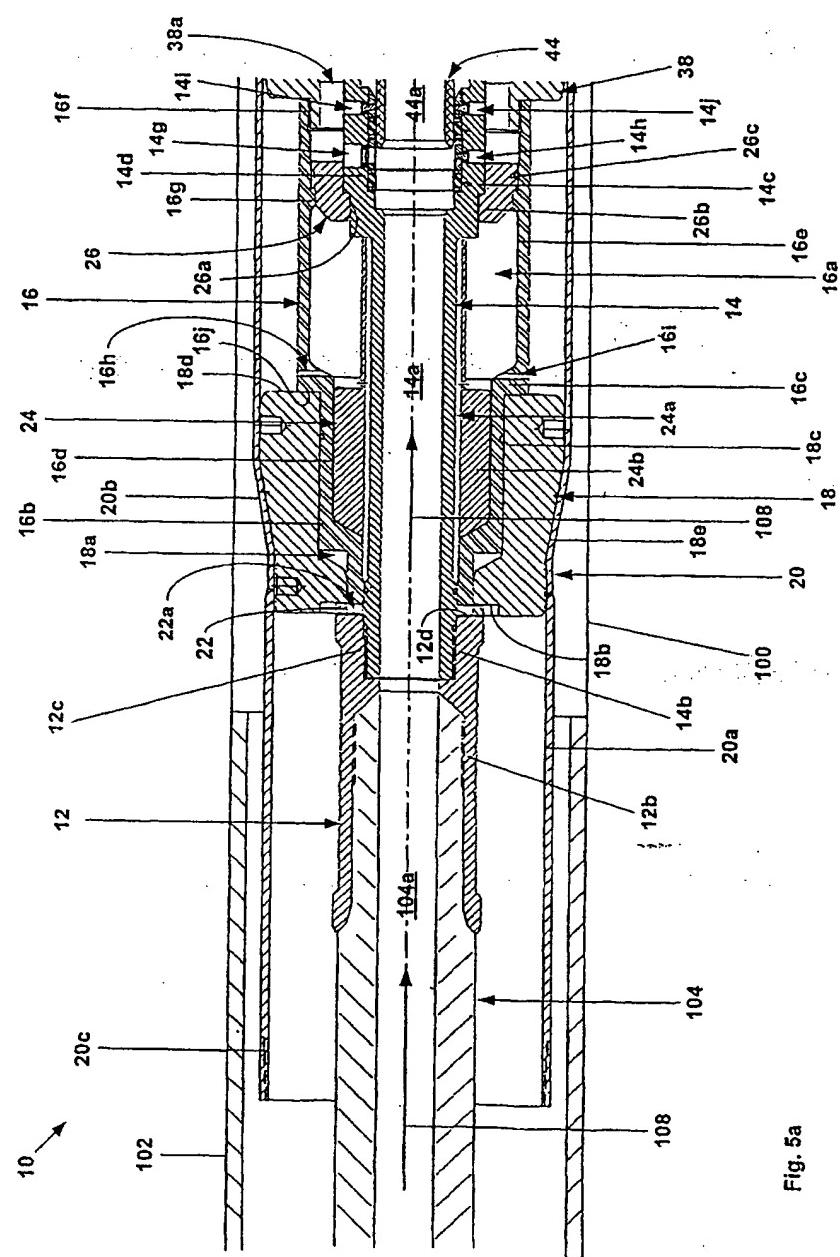
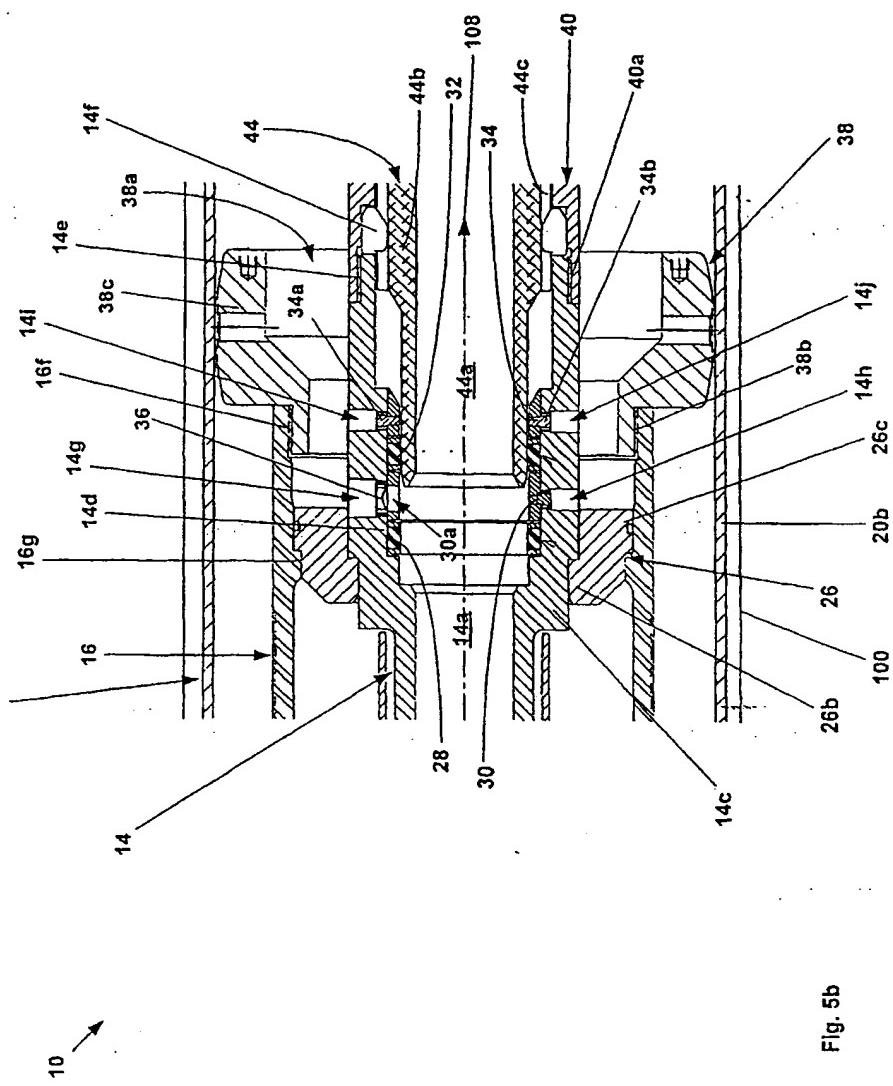
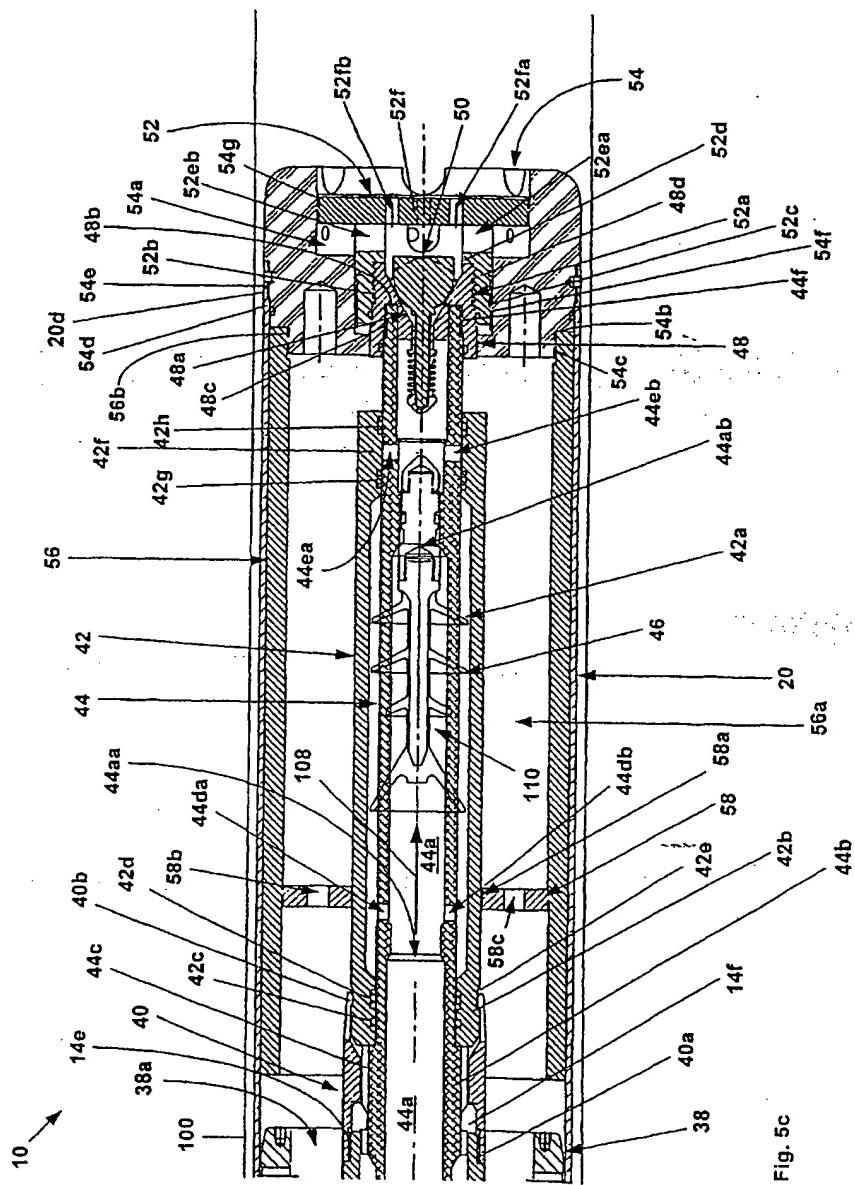


Fig. 5a





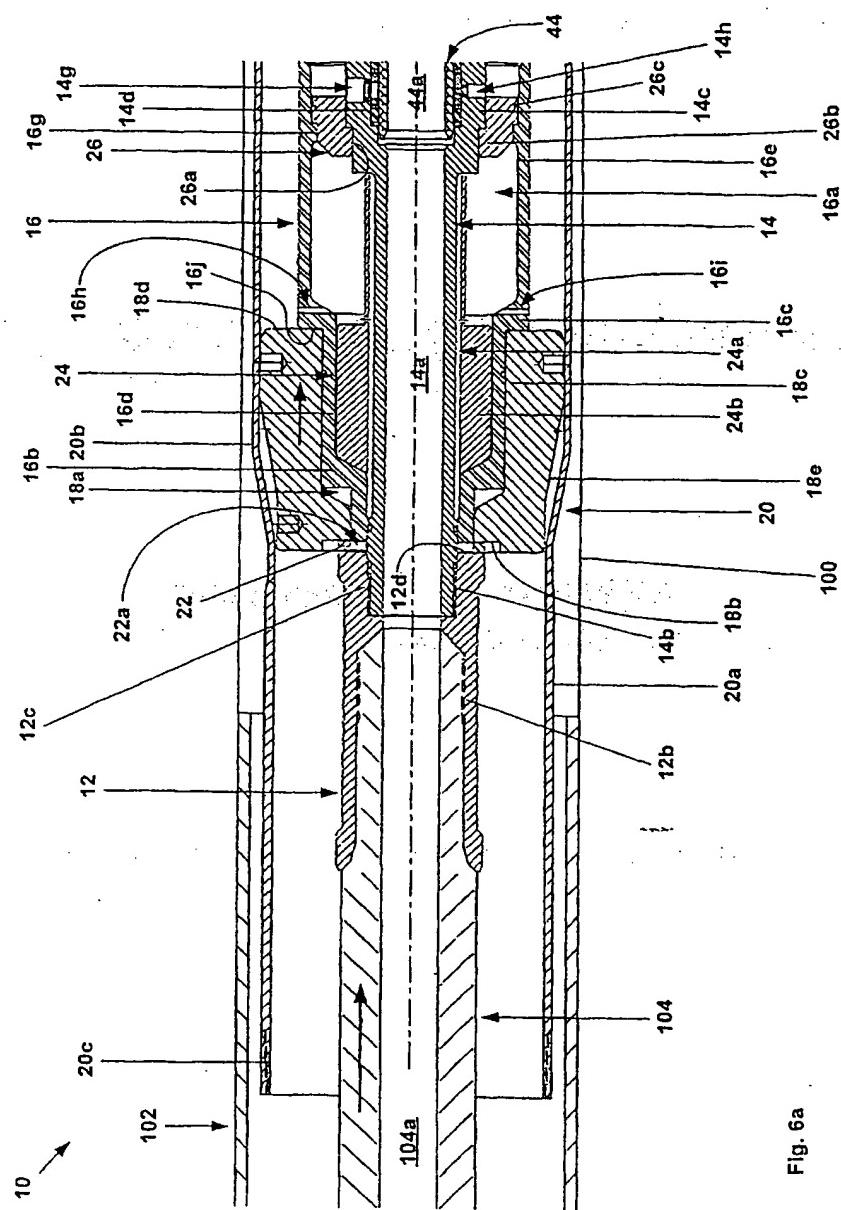


Fig. 6a

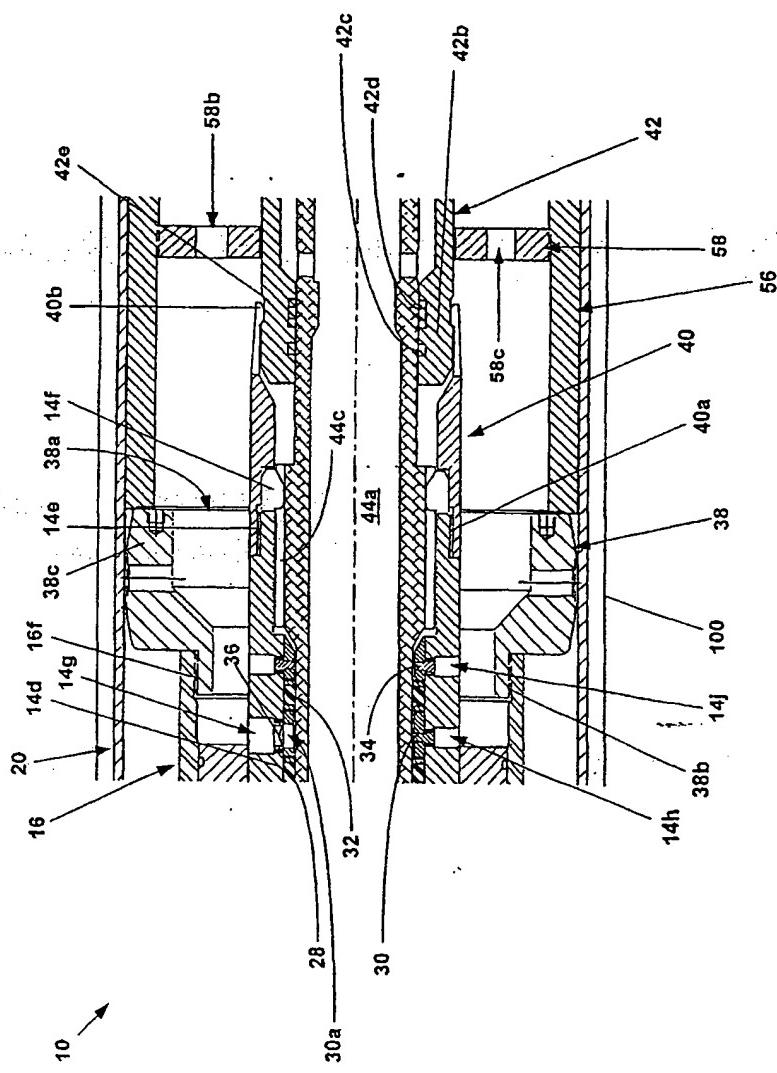
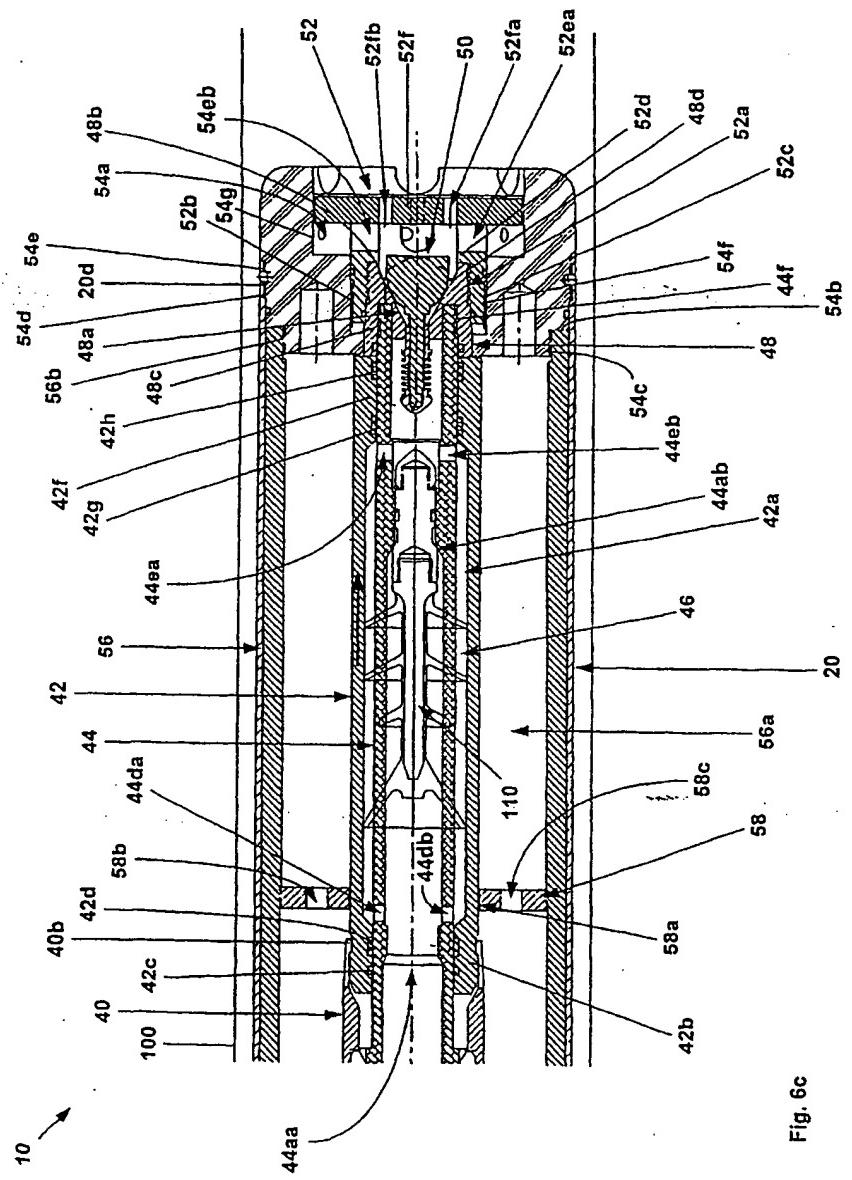


Fig. 6b



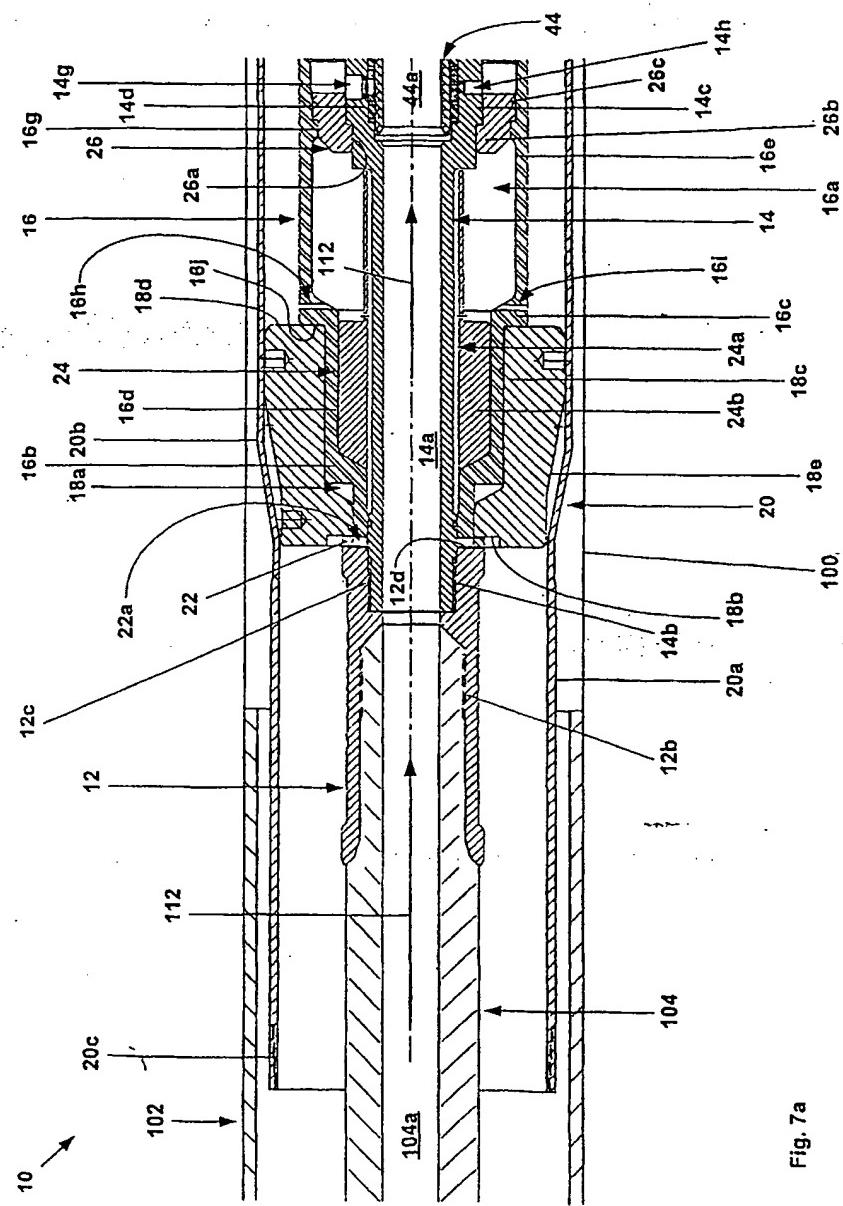


Fig. 7a

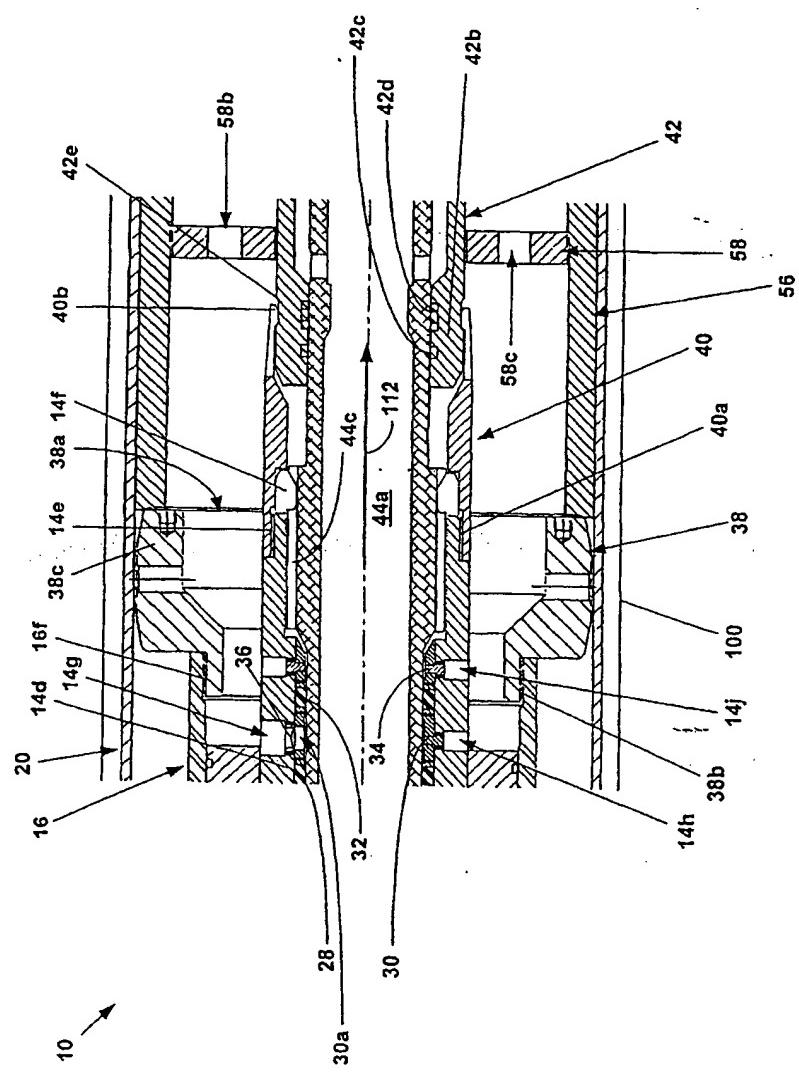
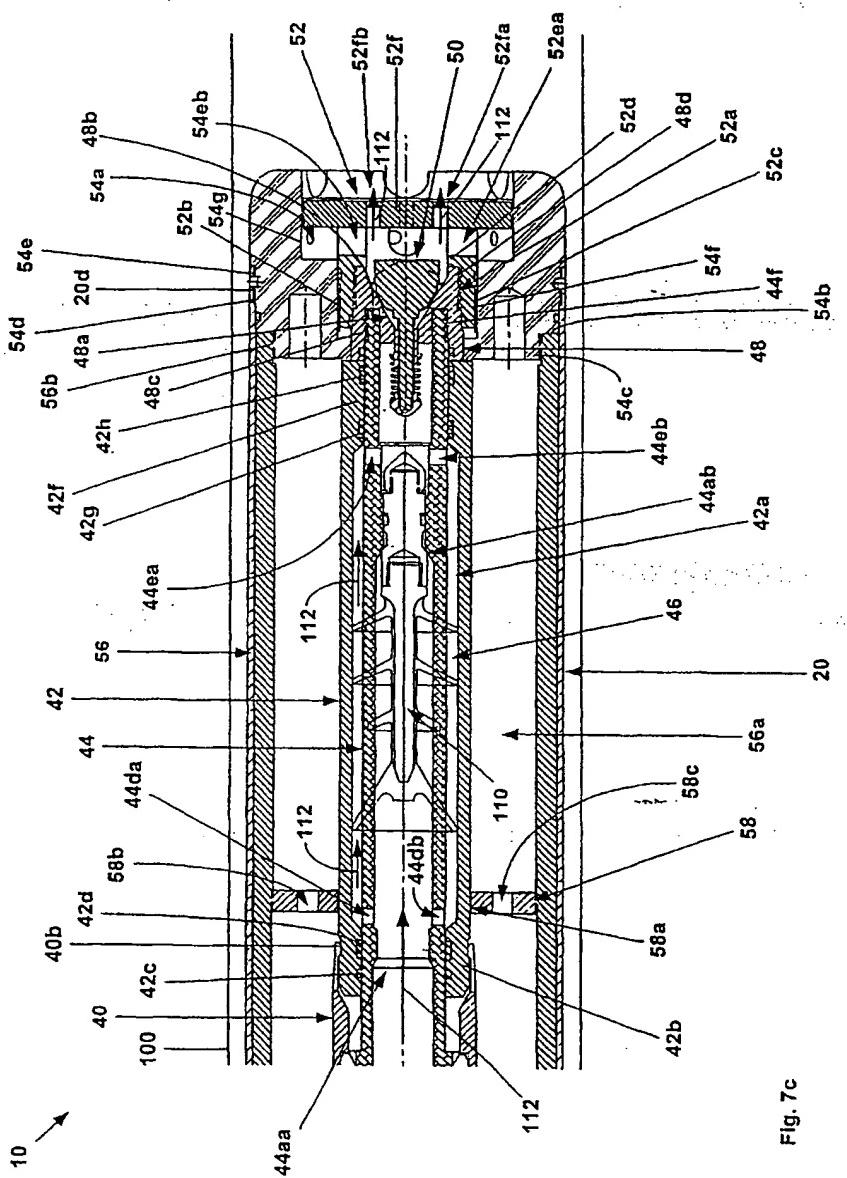


Fig. 7b



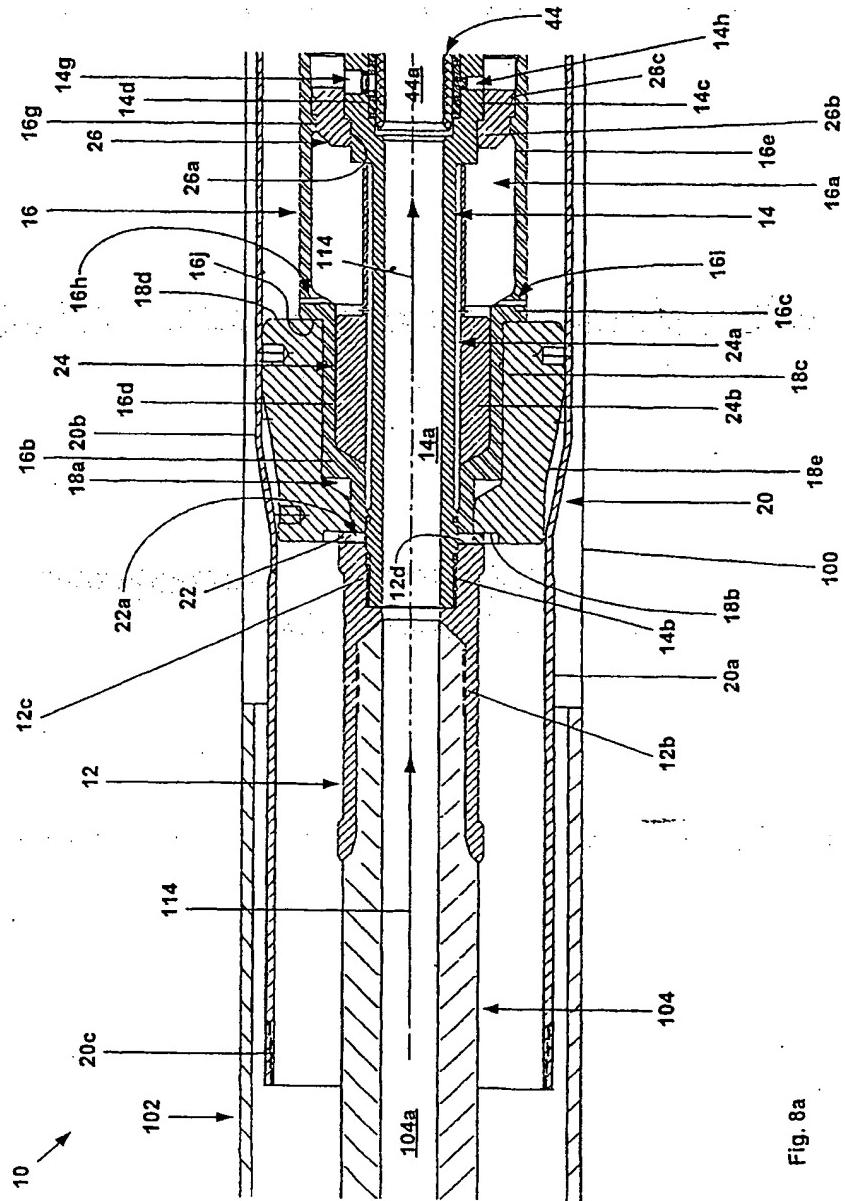


Fig. 8a

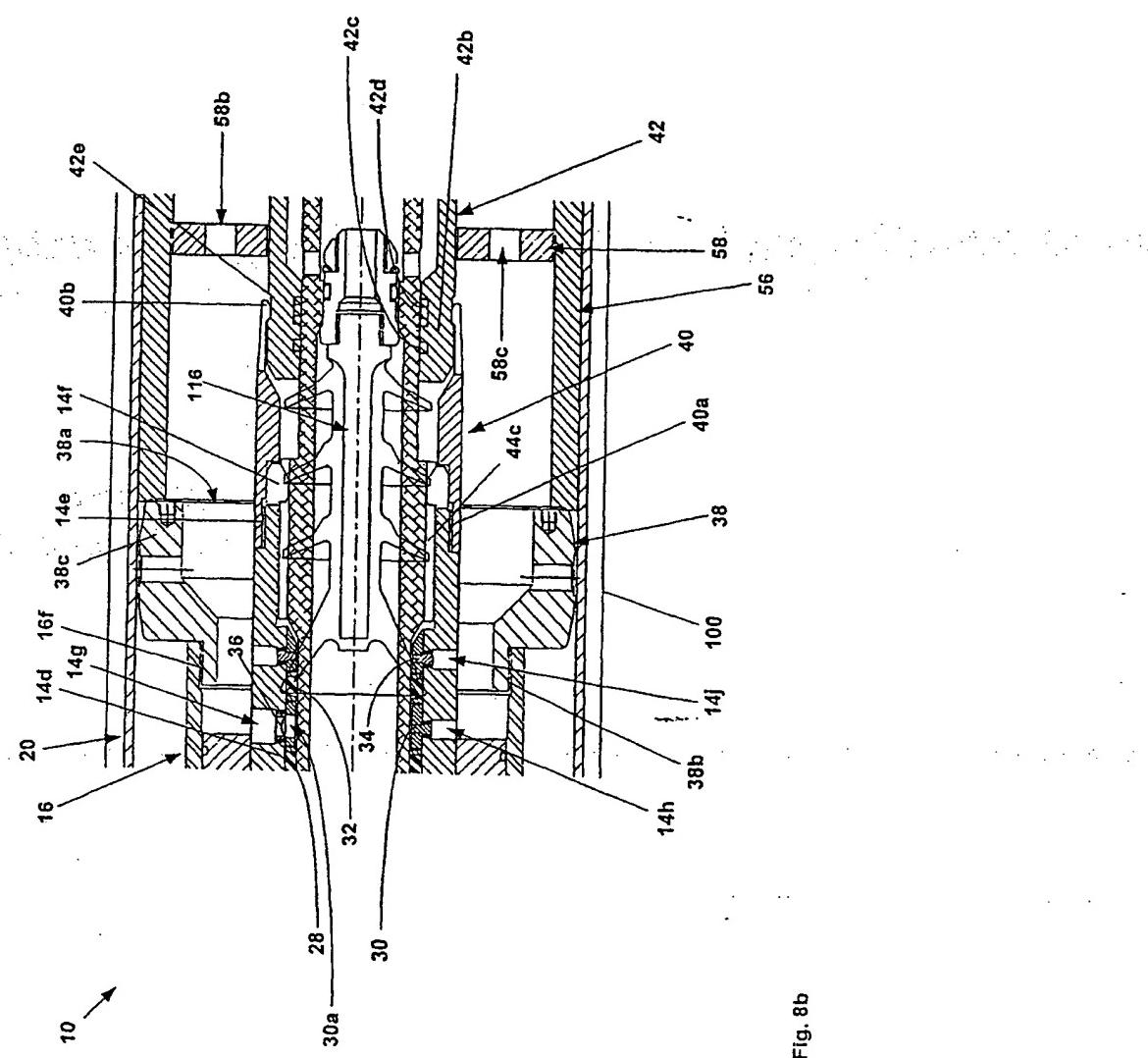
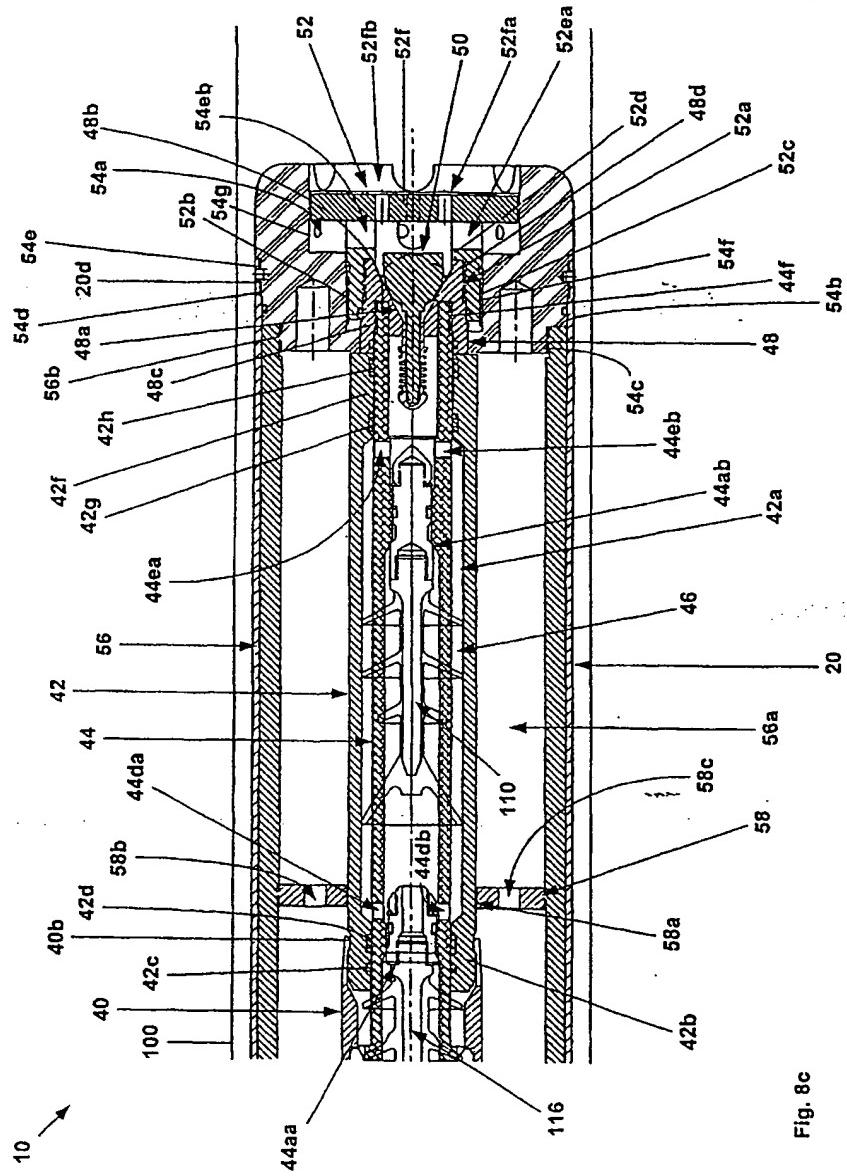


Fig. 8b



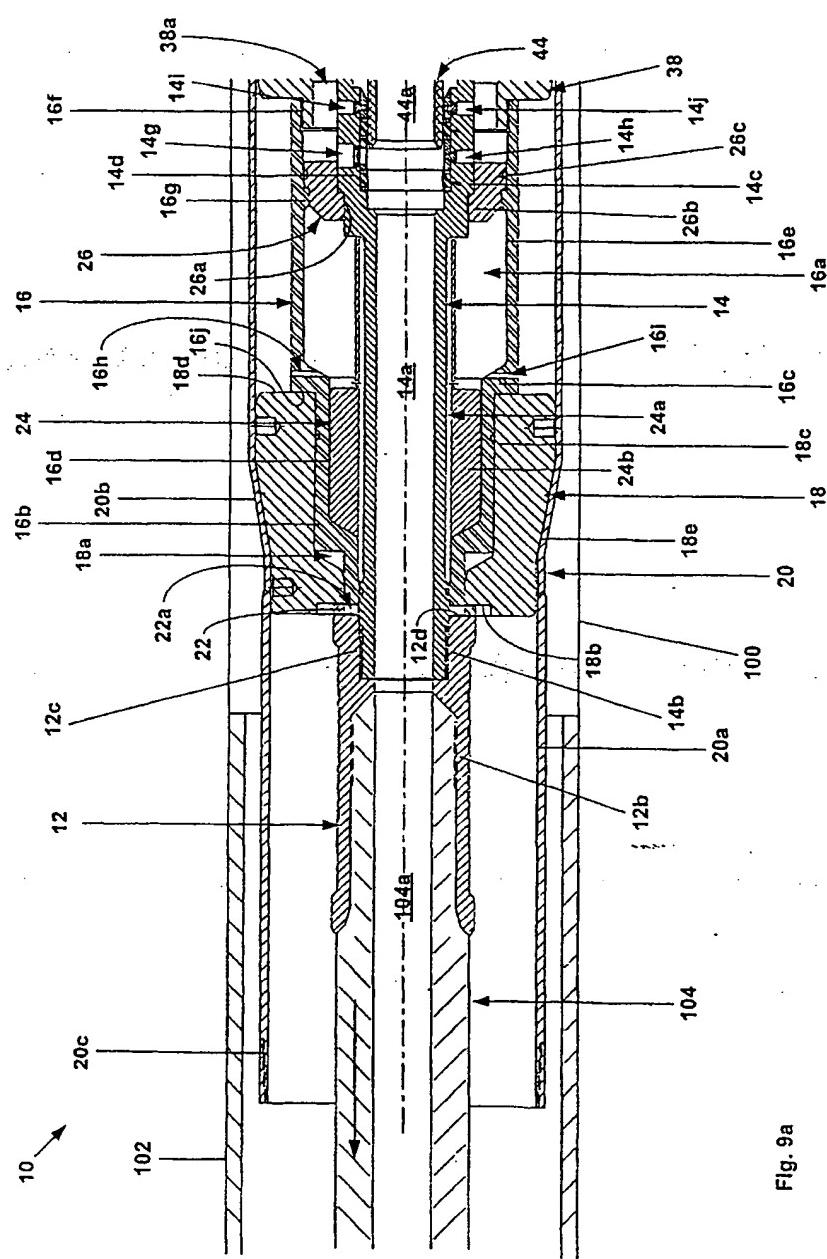


Fig. 9a

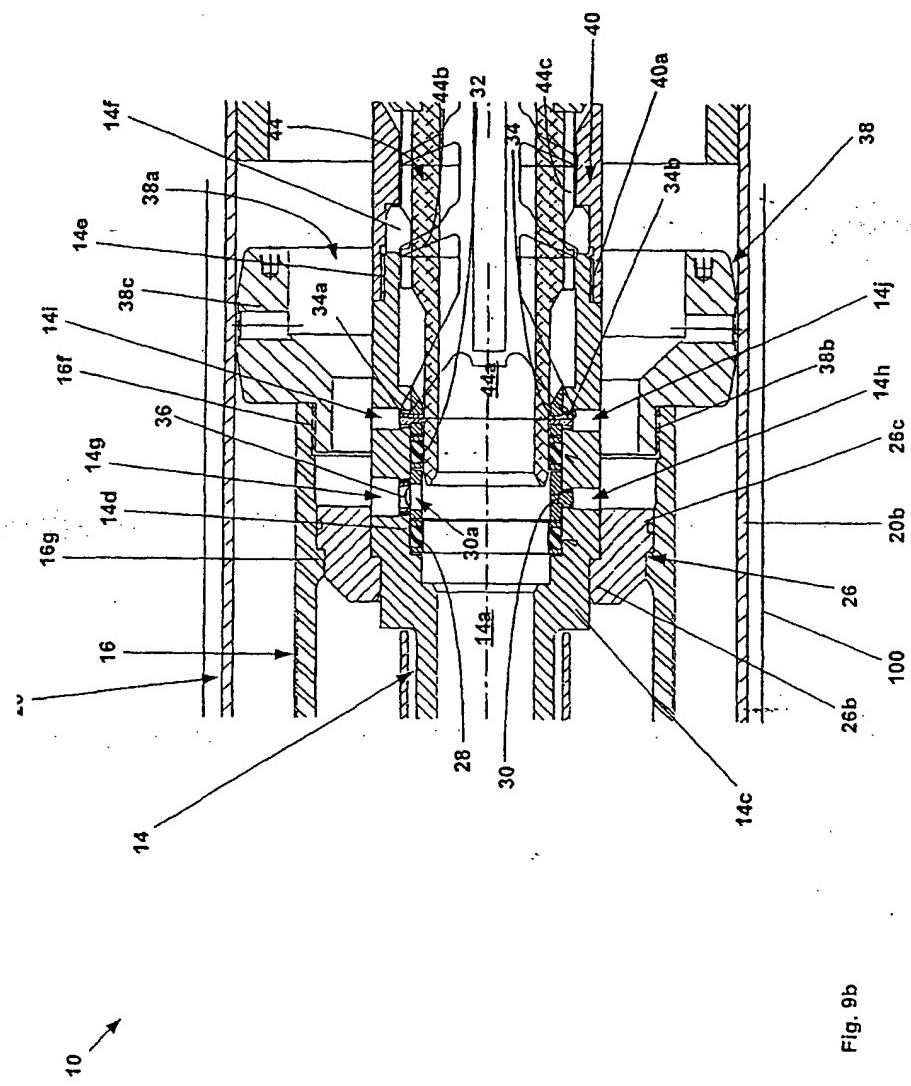


Fig. 9b

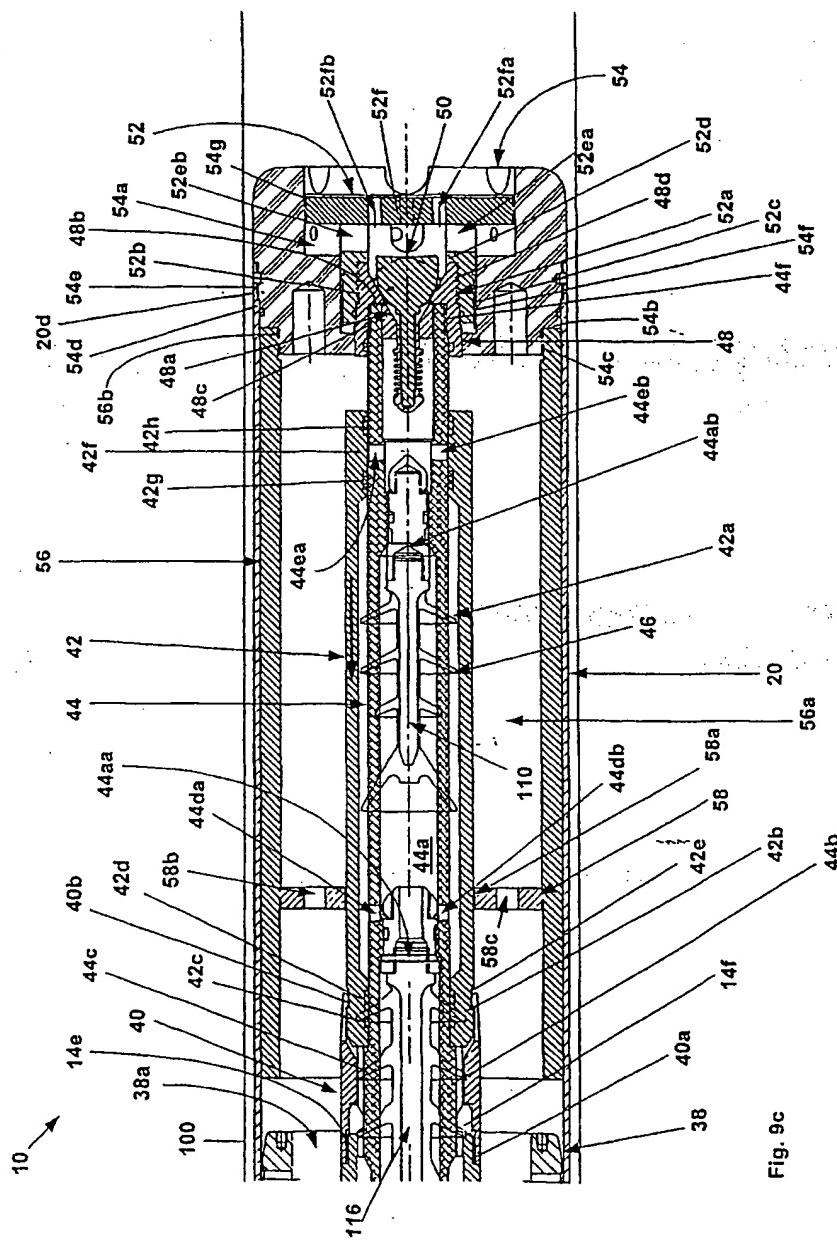


Fig. 9c

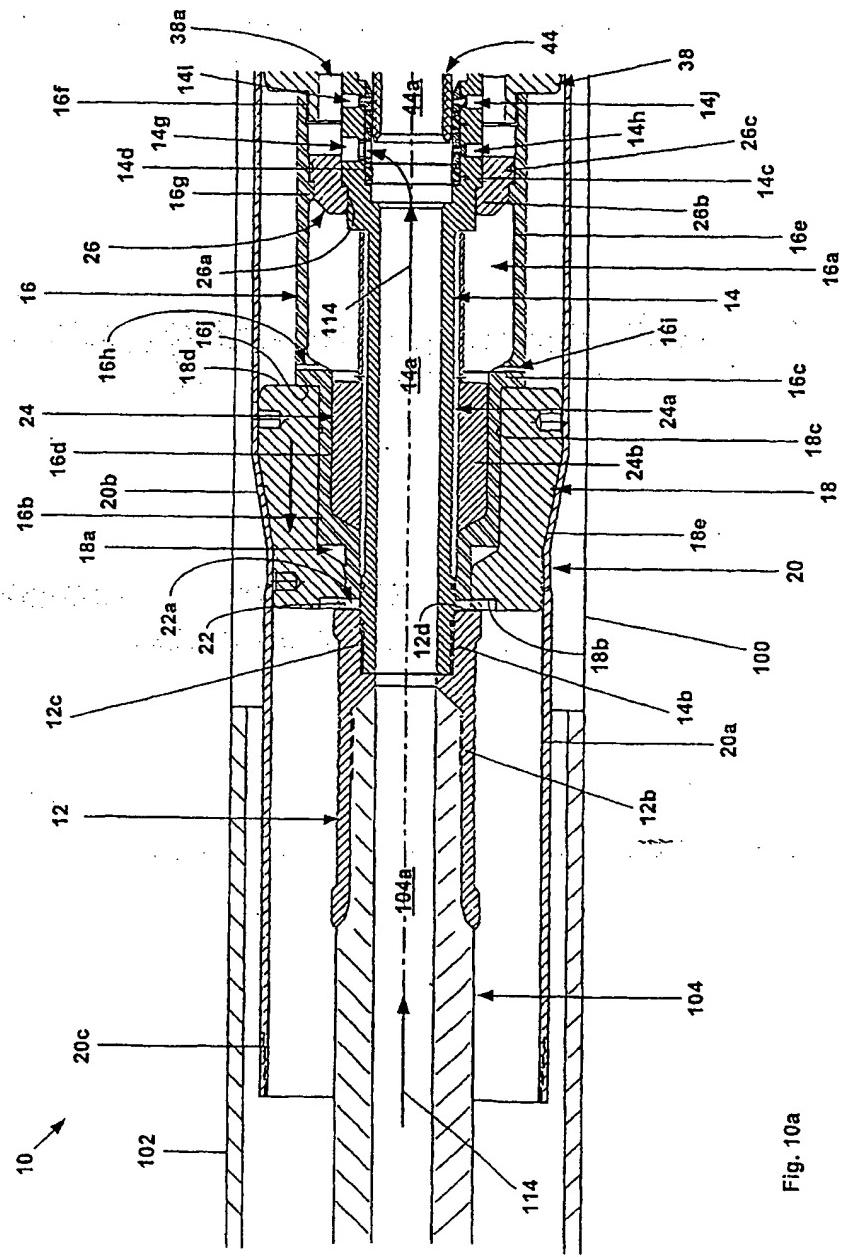


Fig. 10a

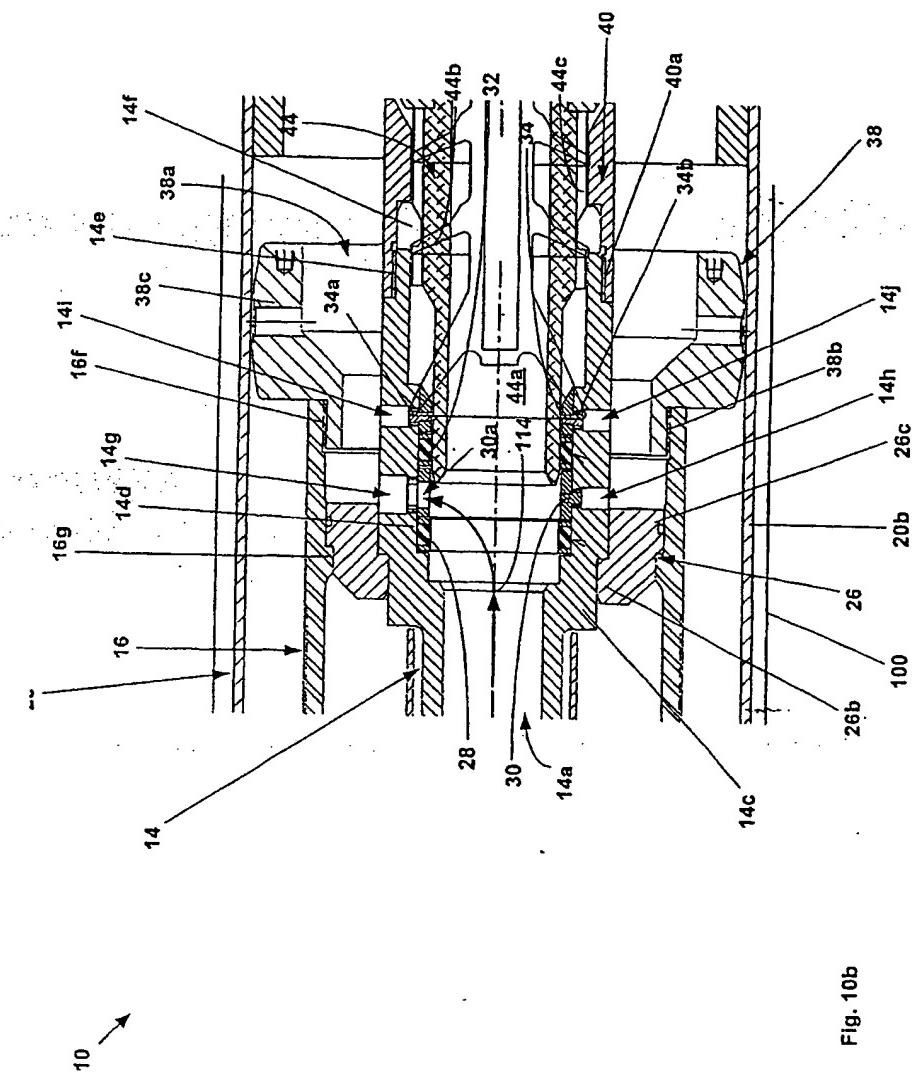
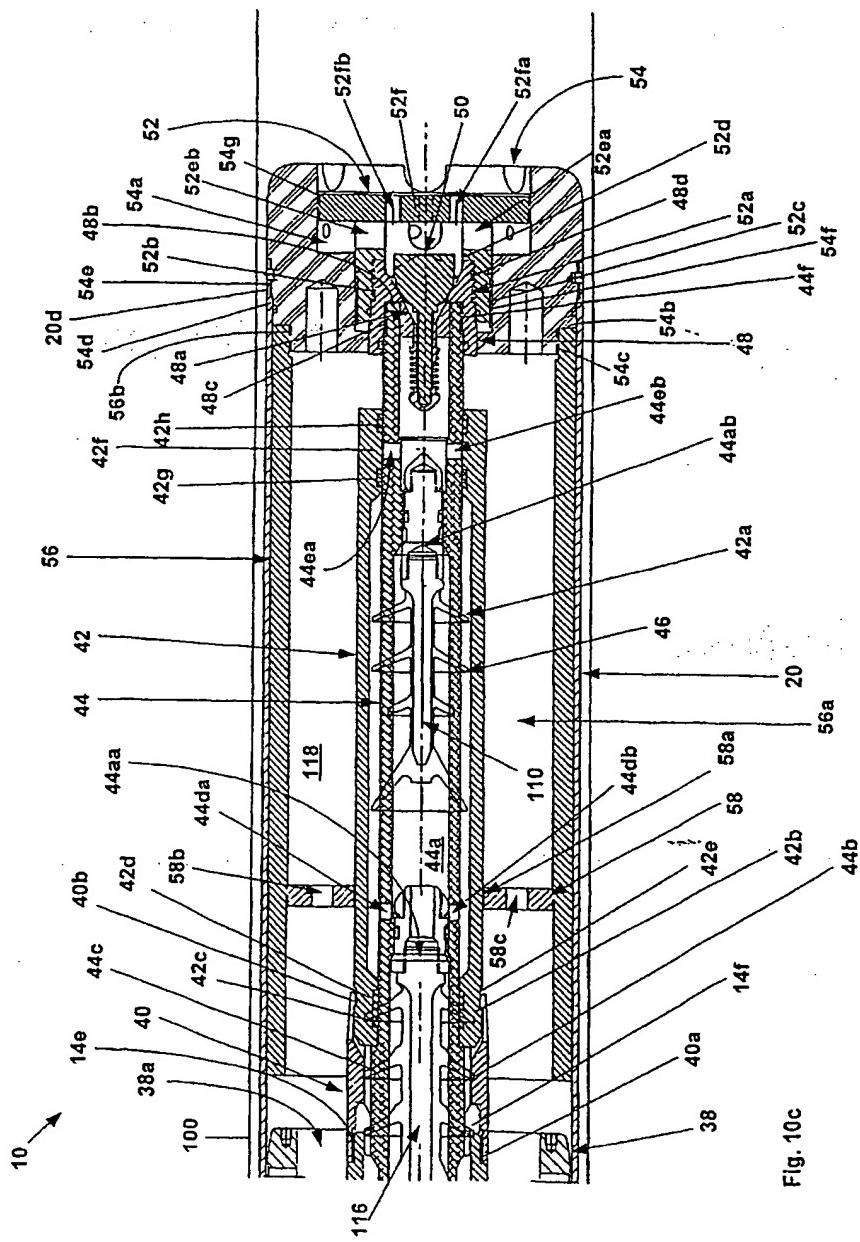


Fig. 10b



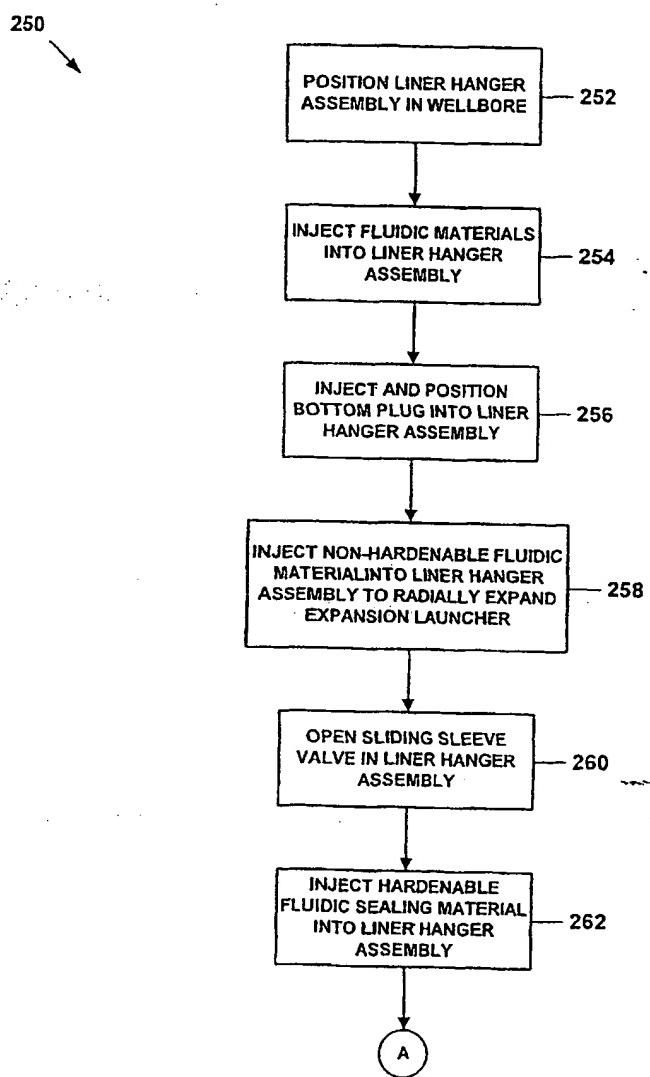


Fig. 11a

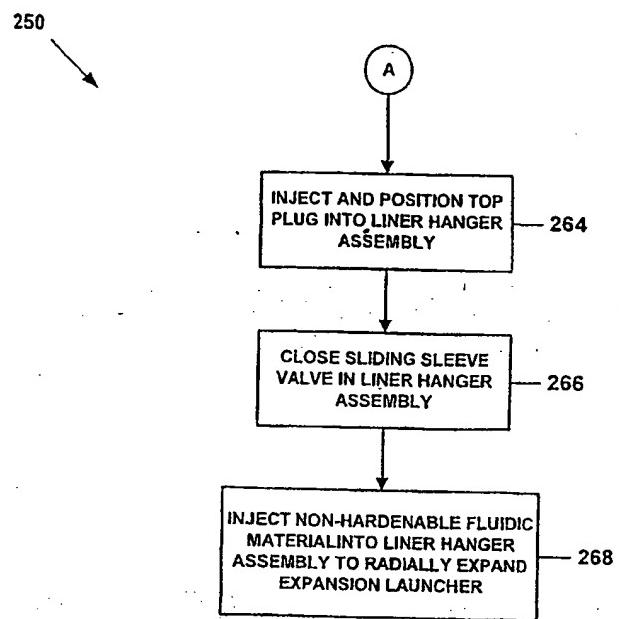


Fig. 11b

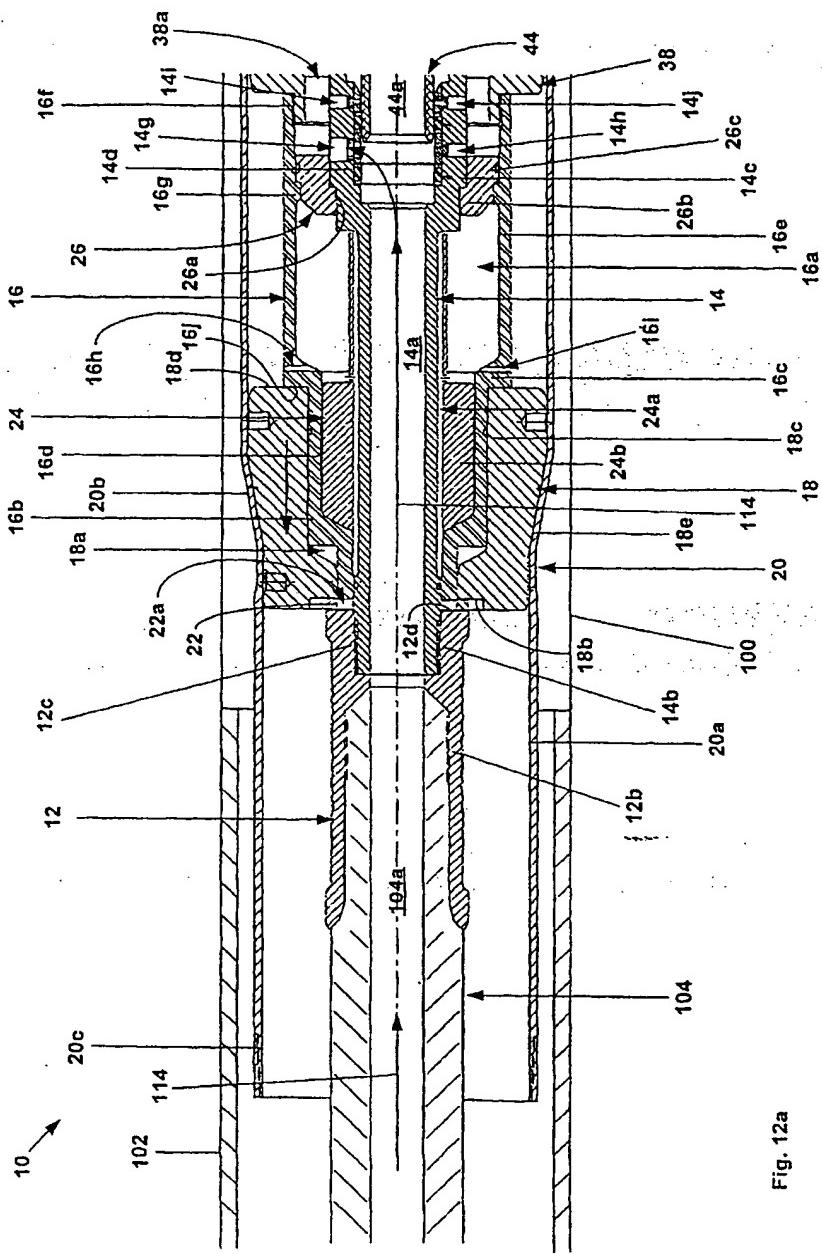


Fig. 12a

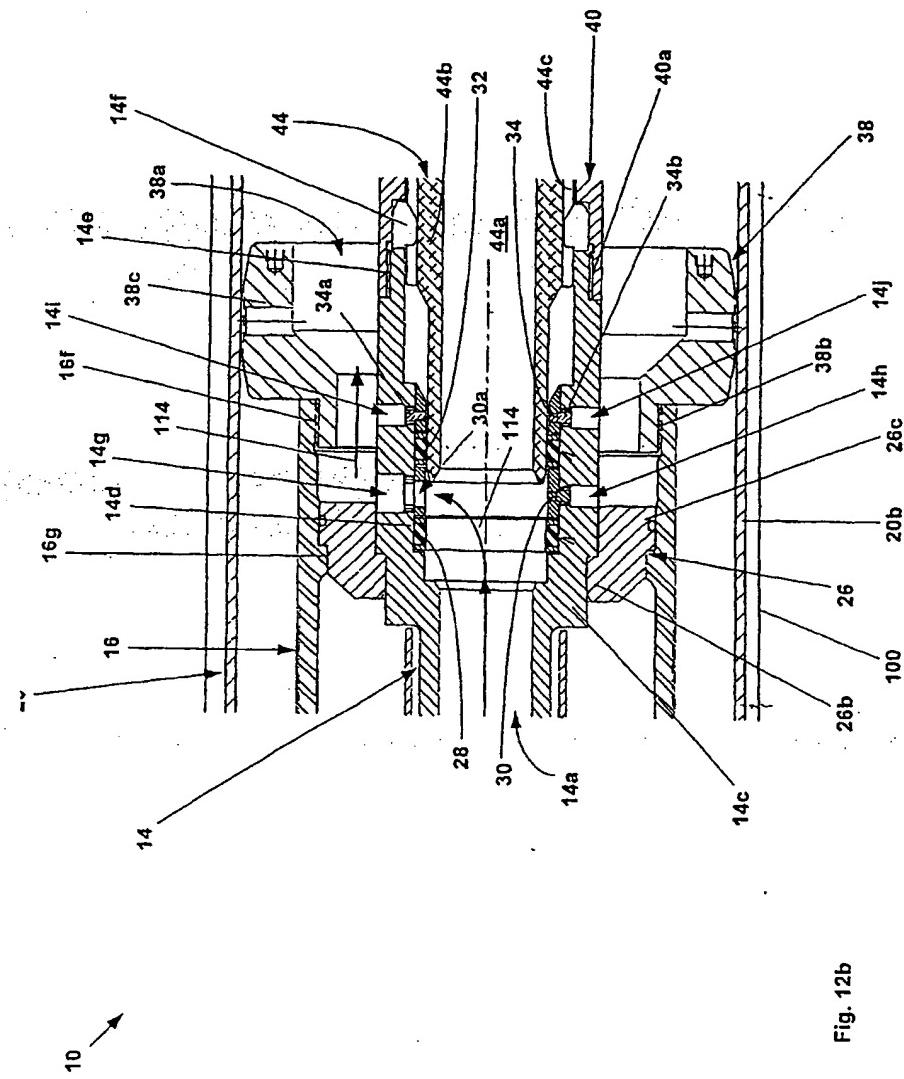


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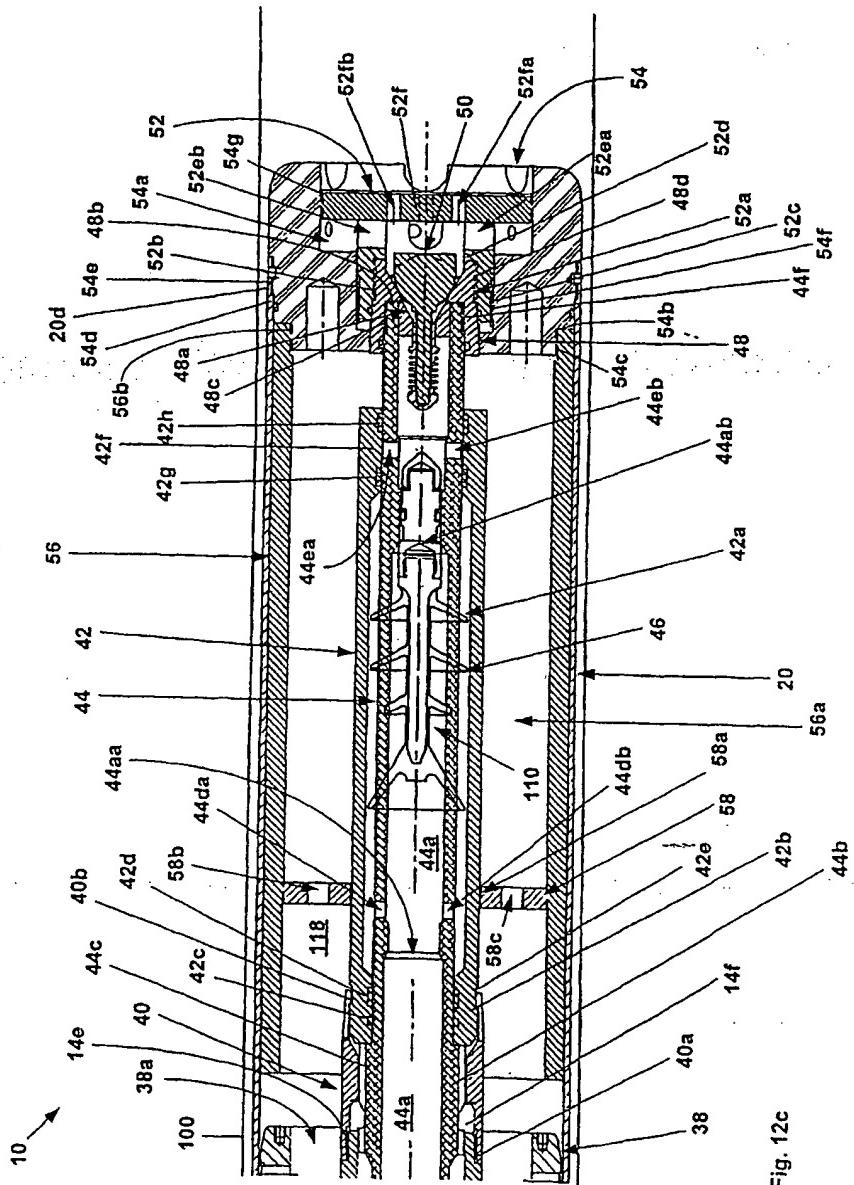


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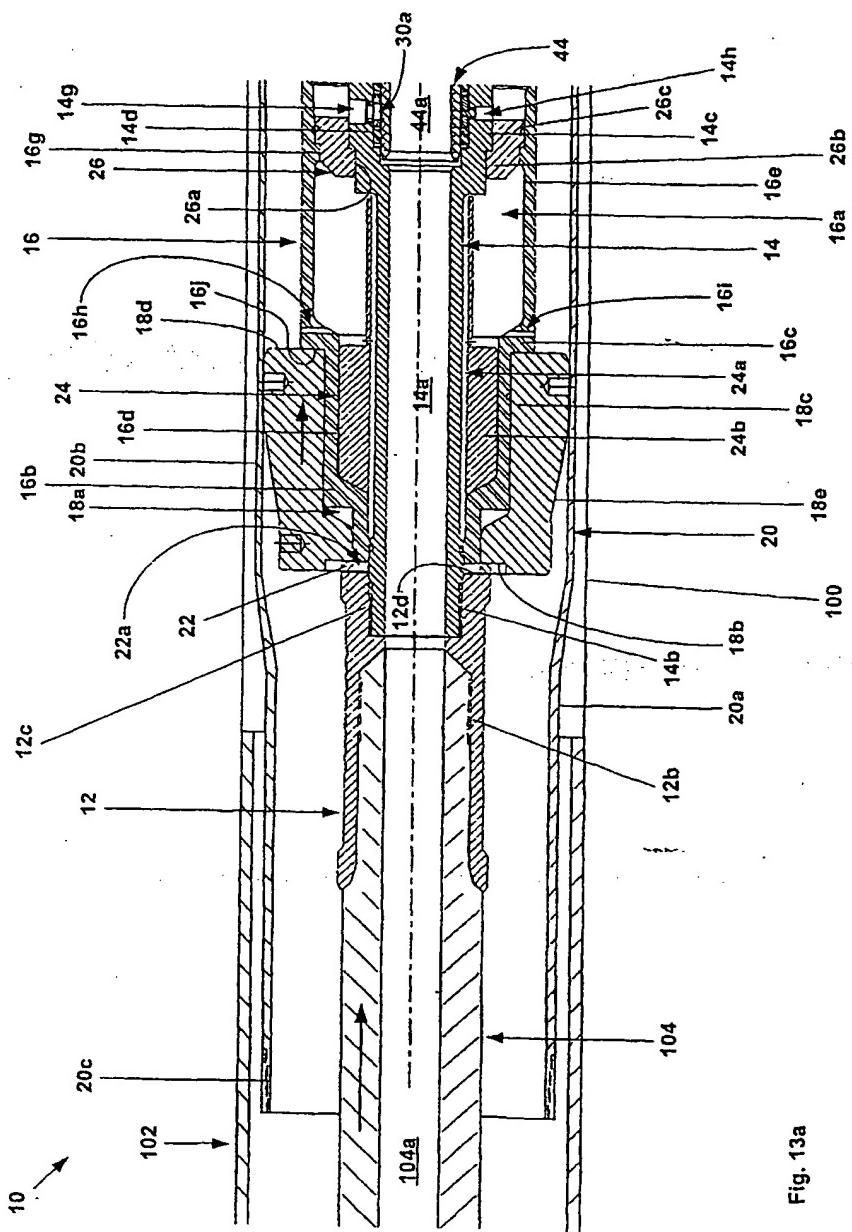


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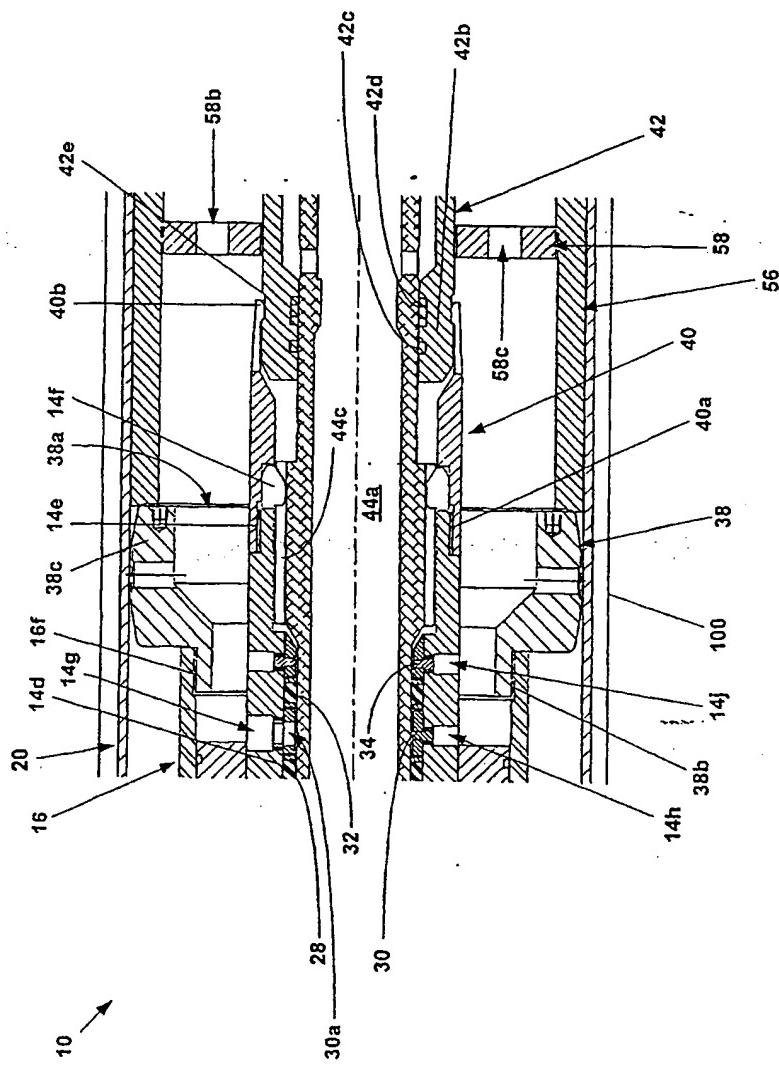


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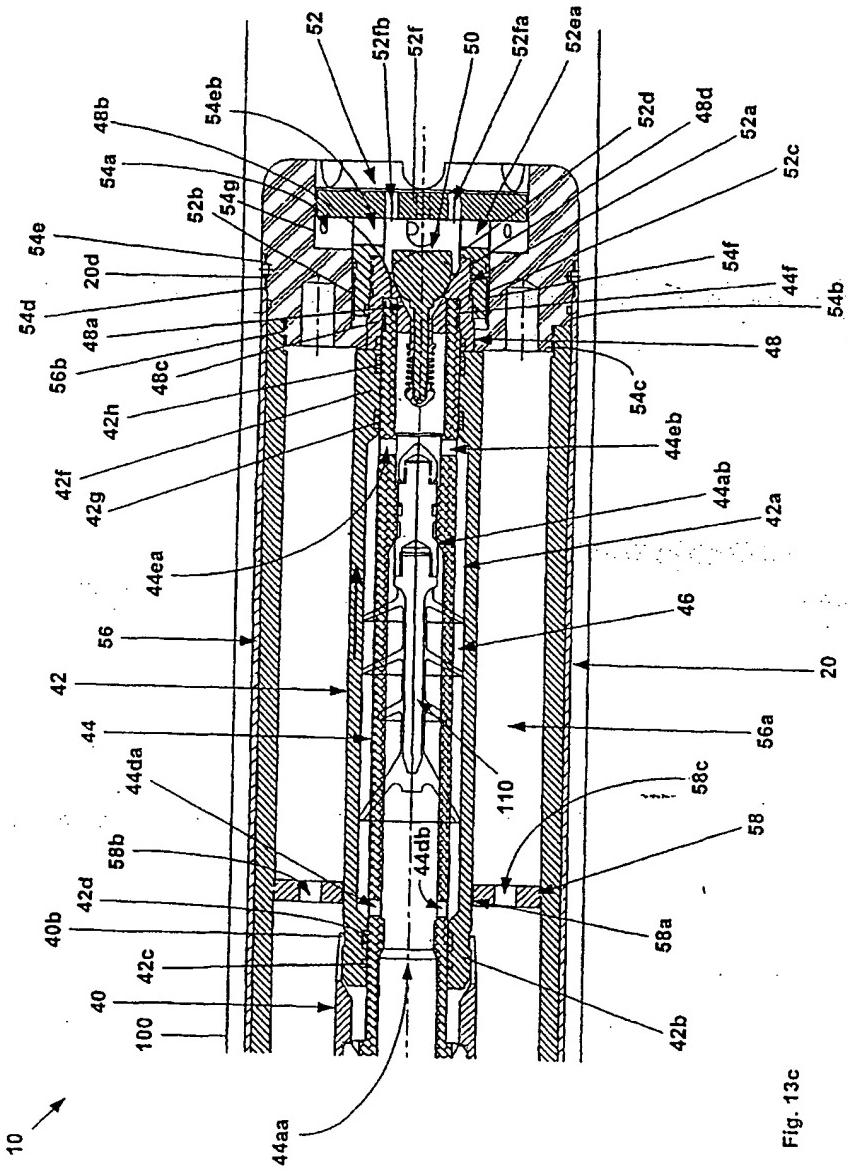


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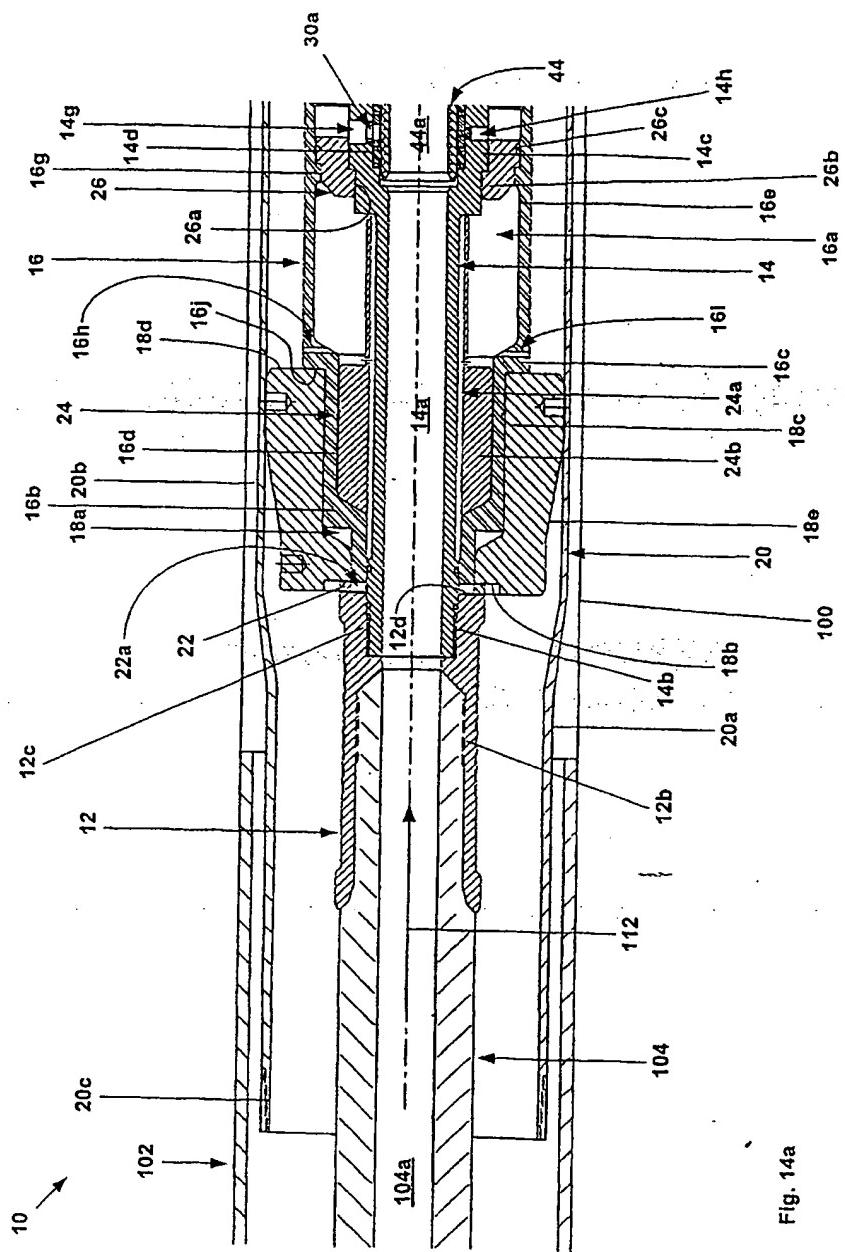


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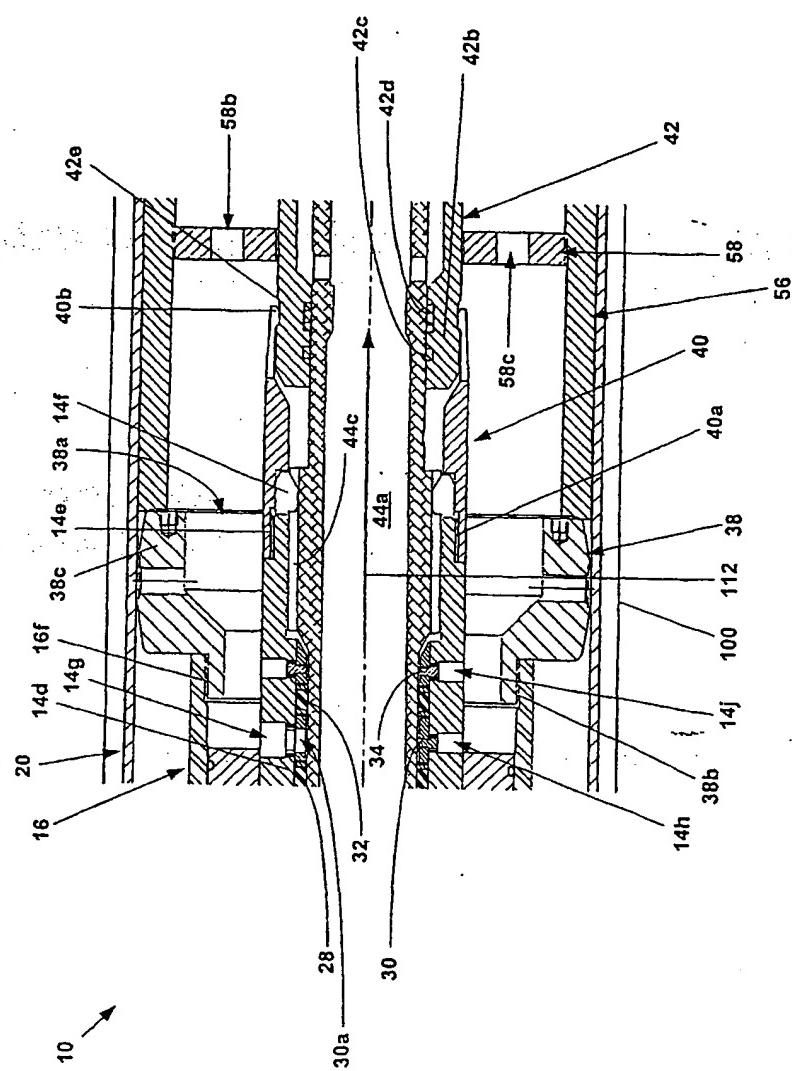
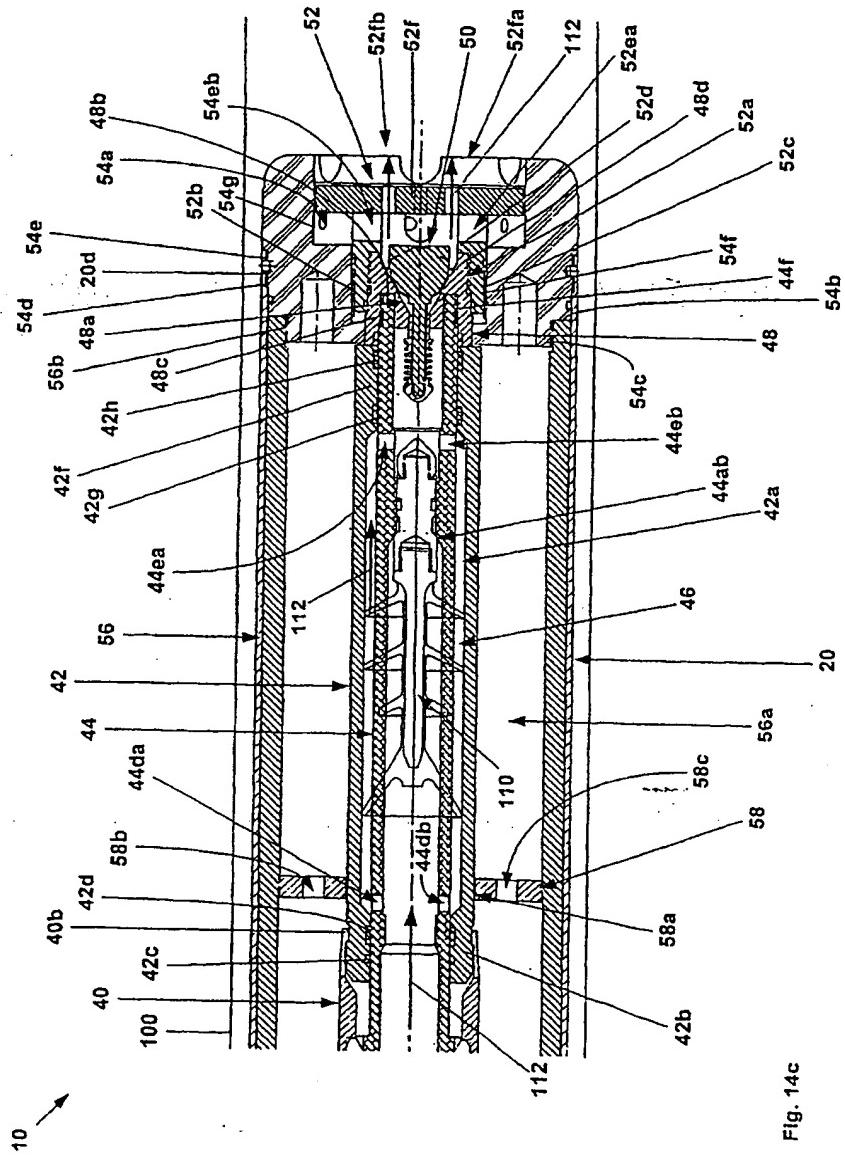


Fig. 14b



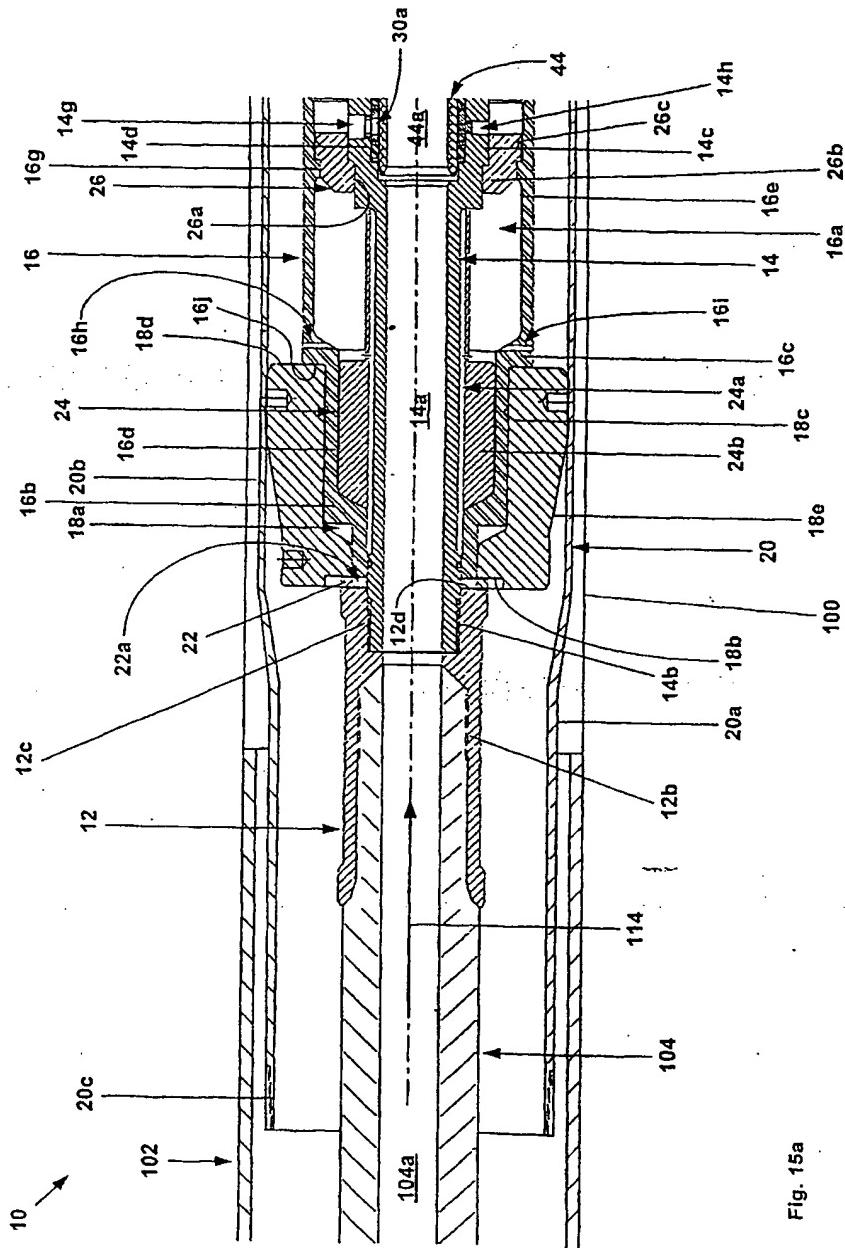


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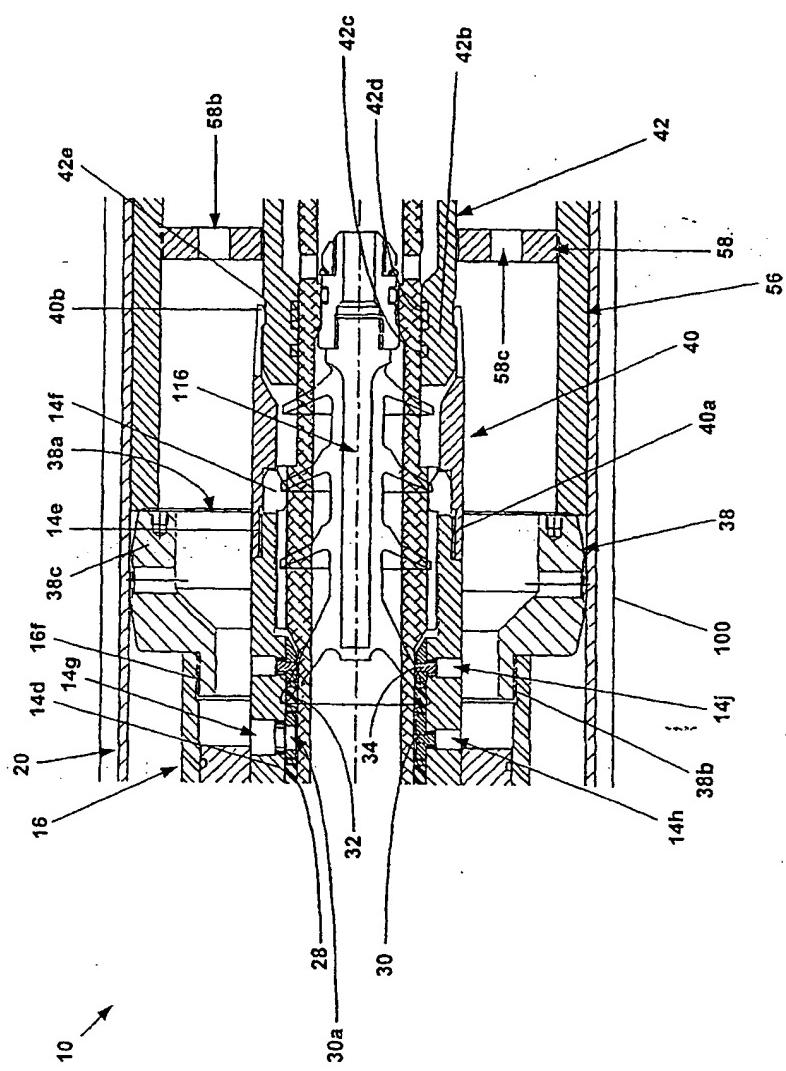
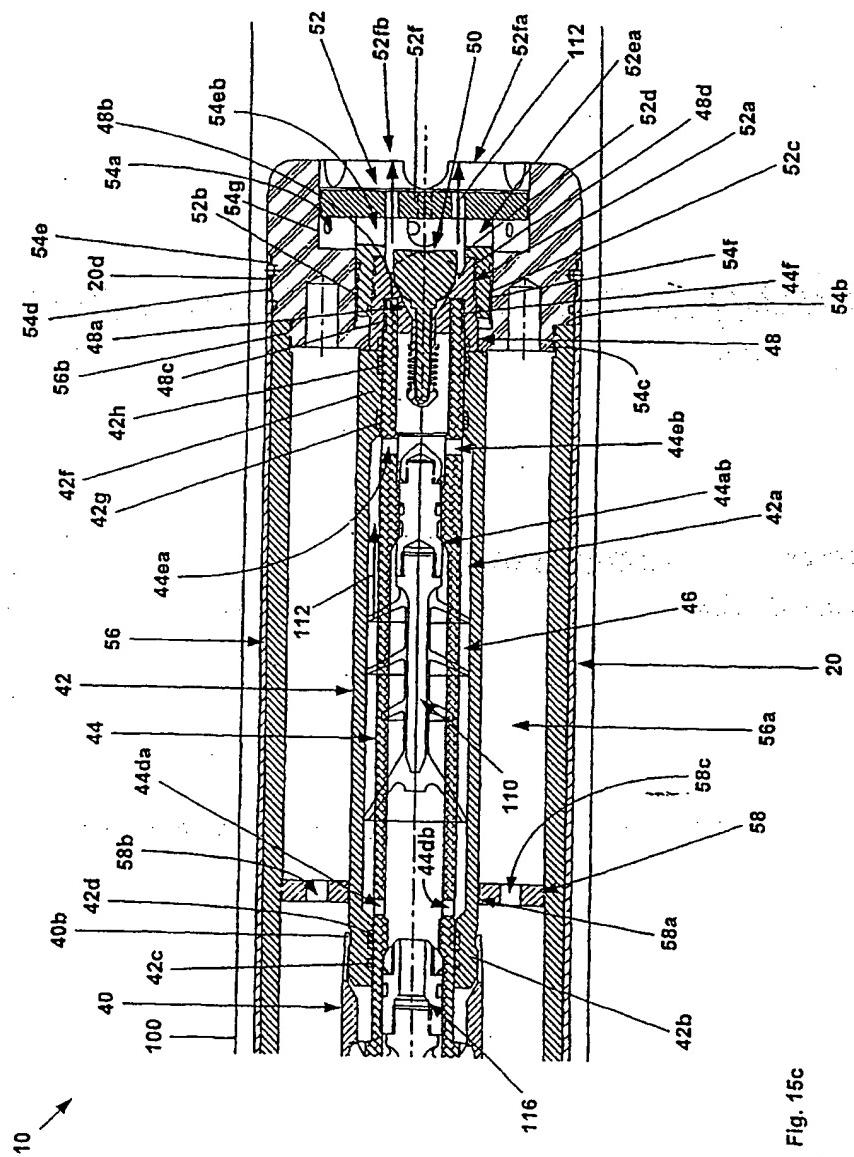


Fig. 15b



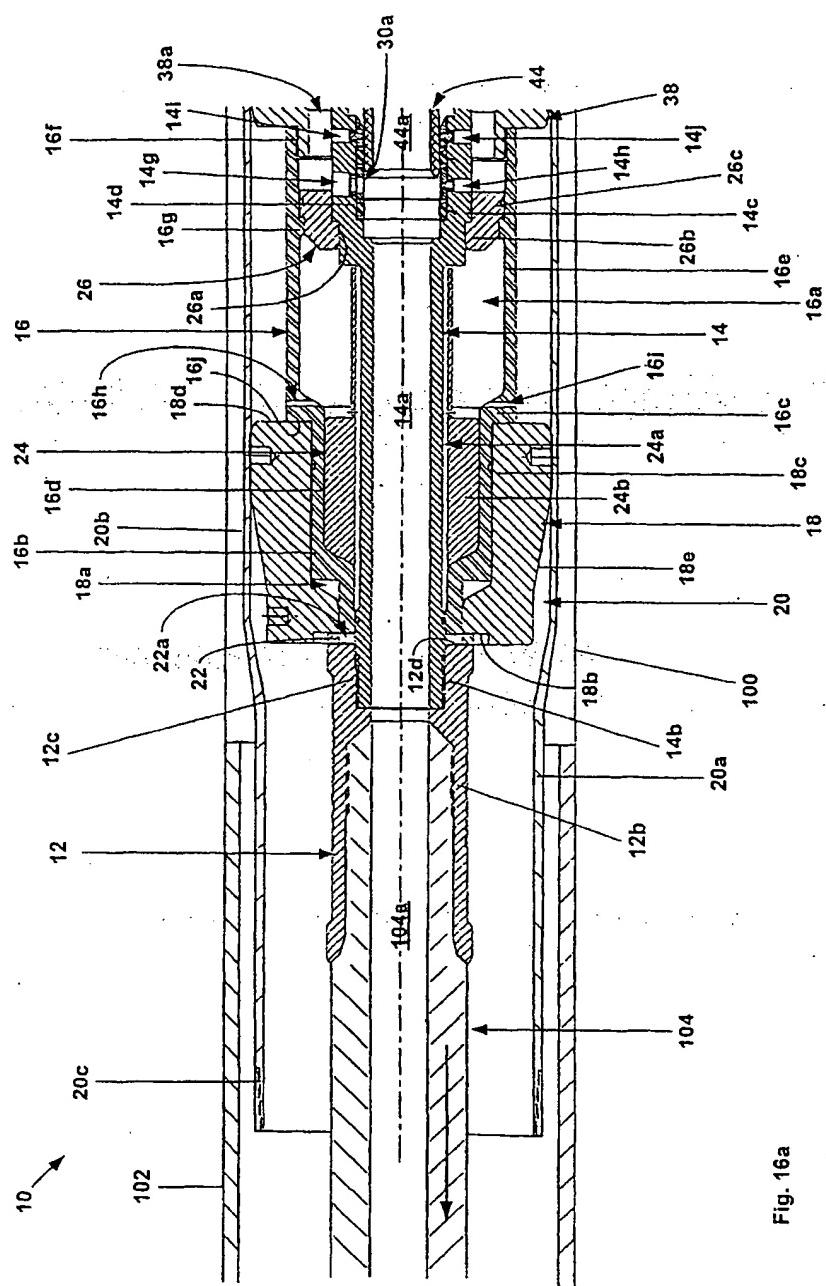


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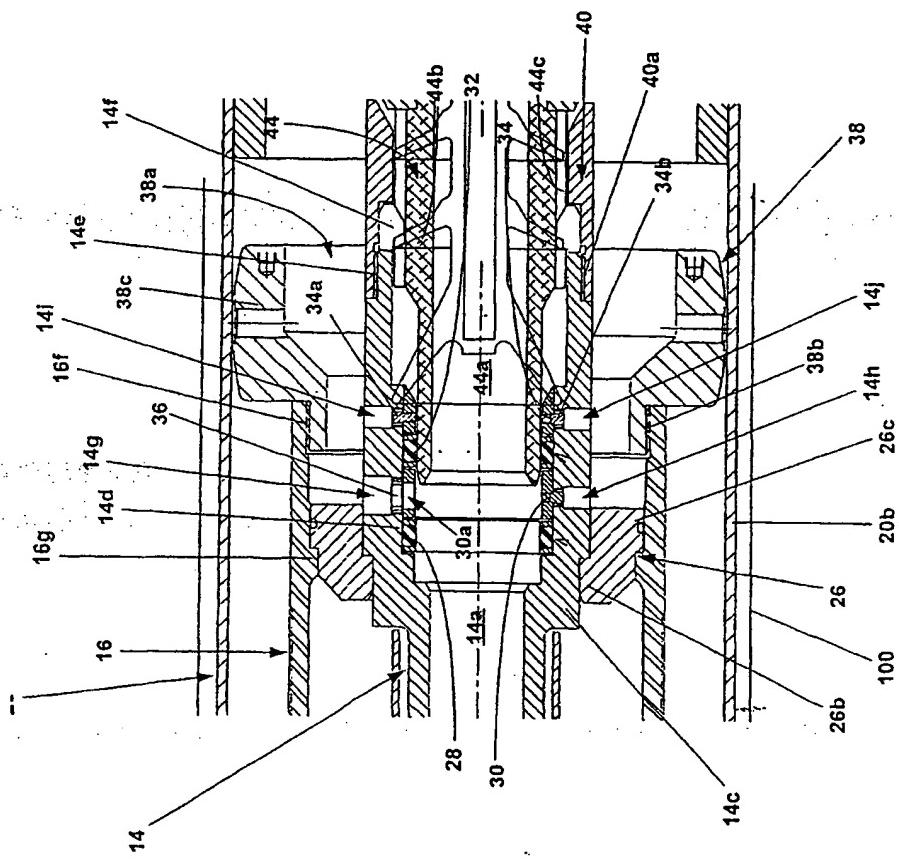


Fig. 16b

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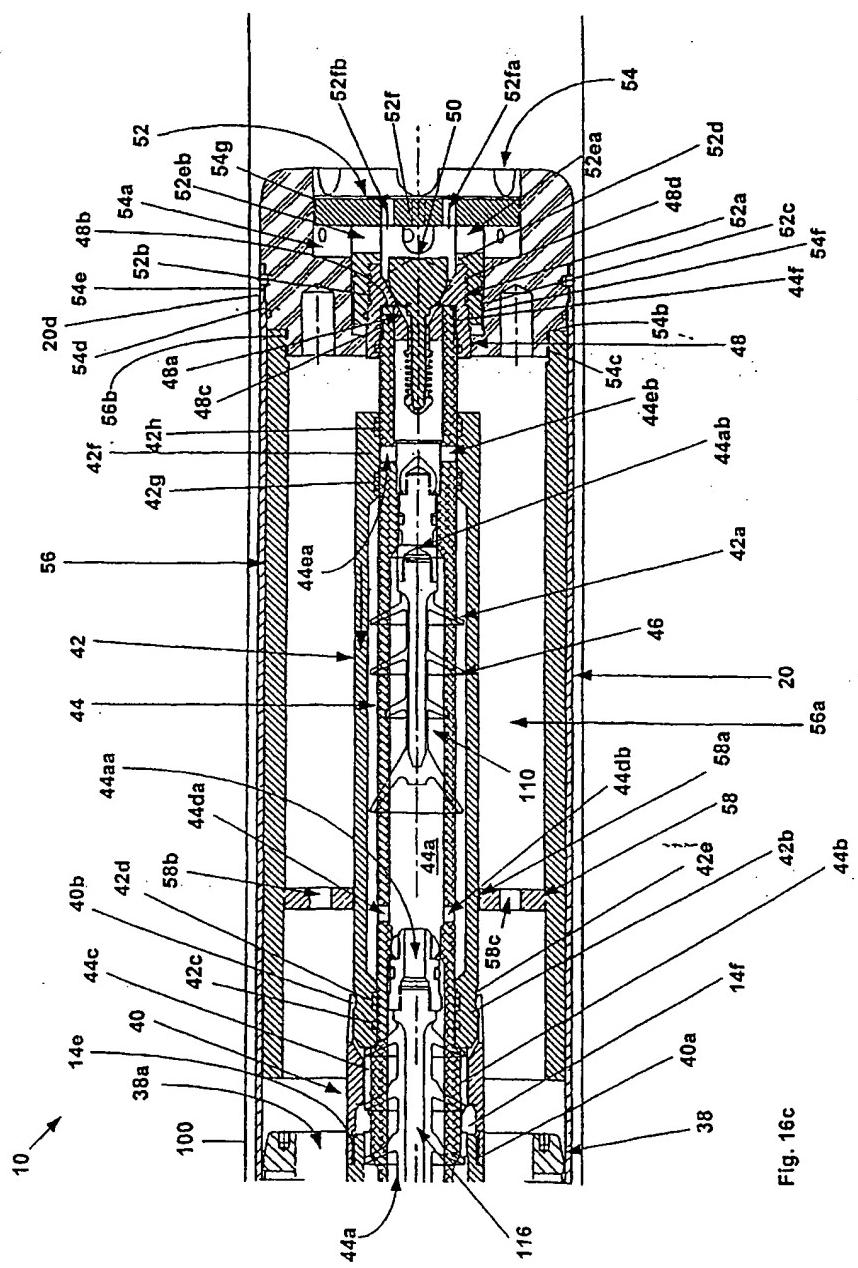


Fig. 16c

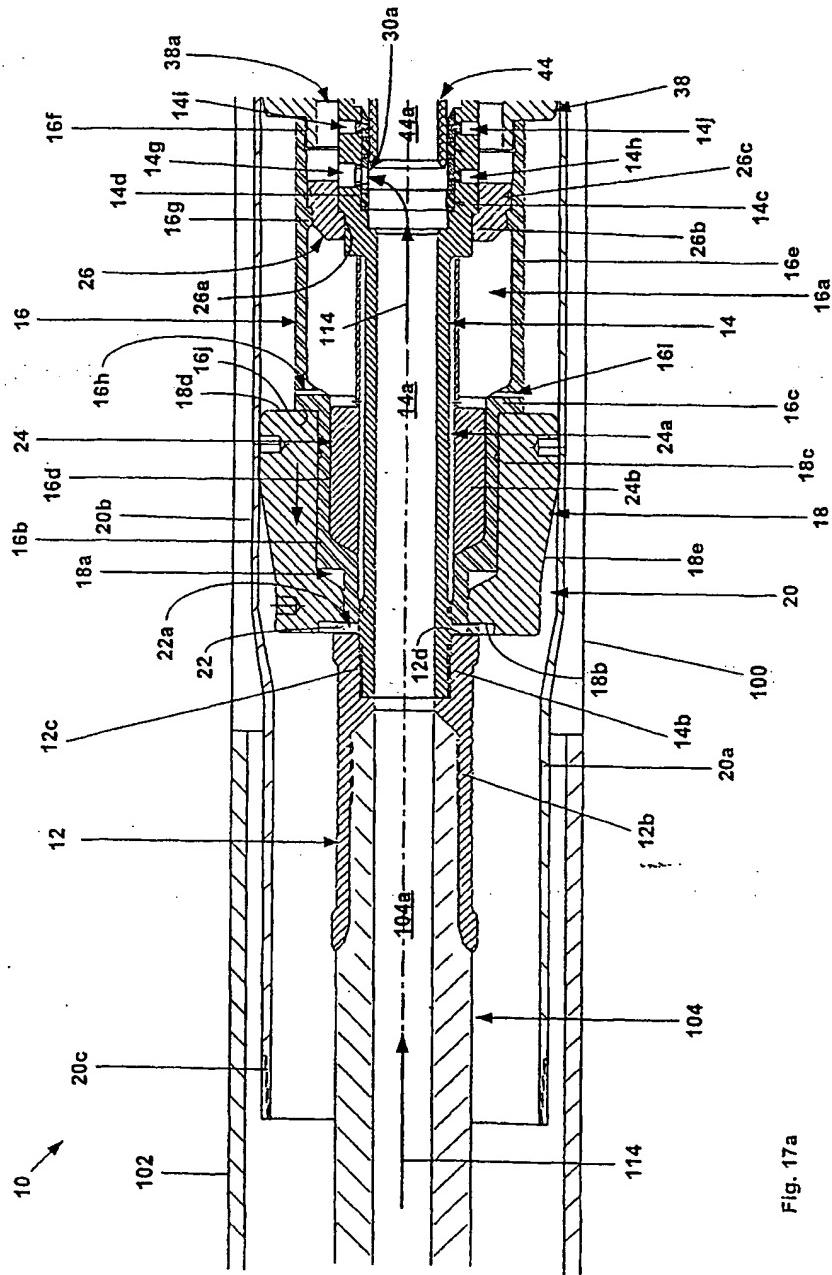
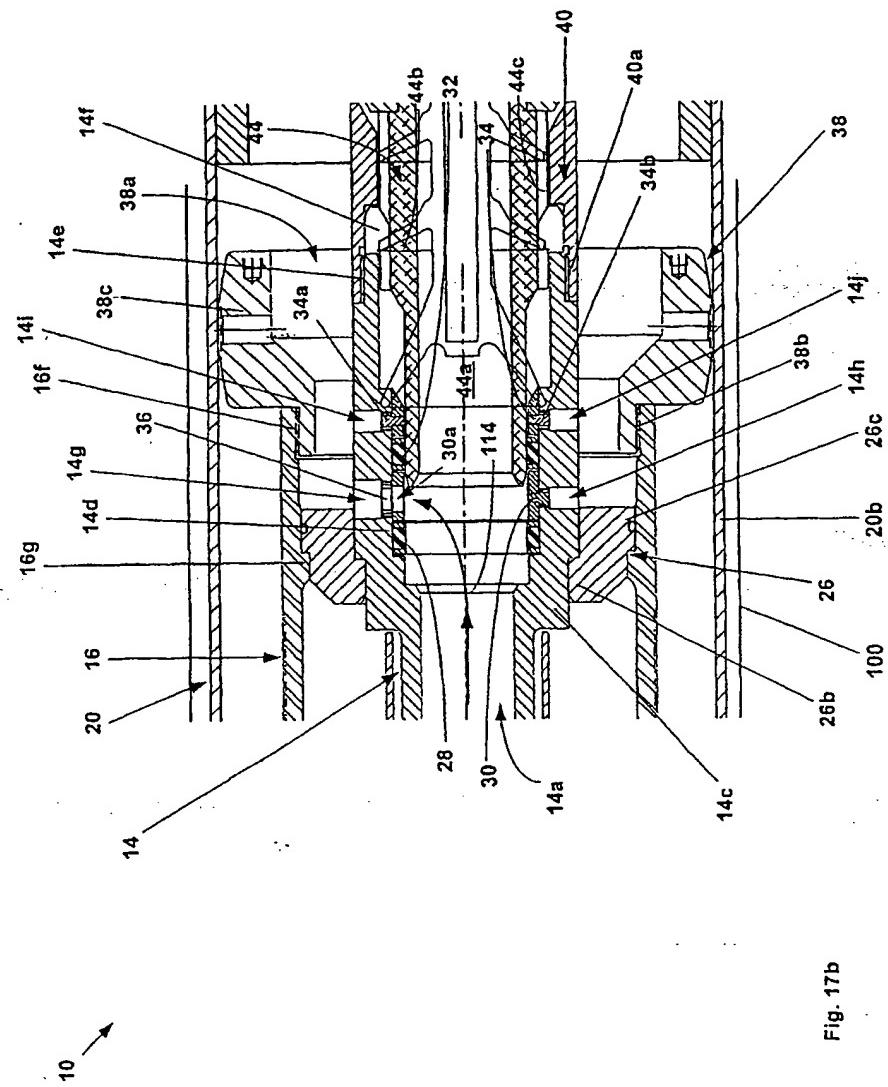
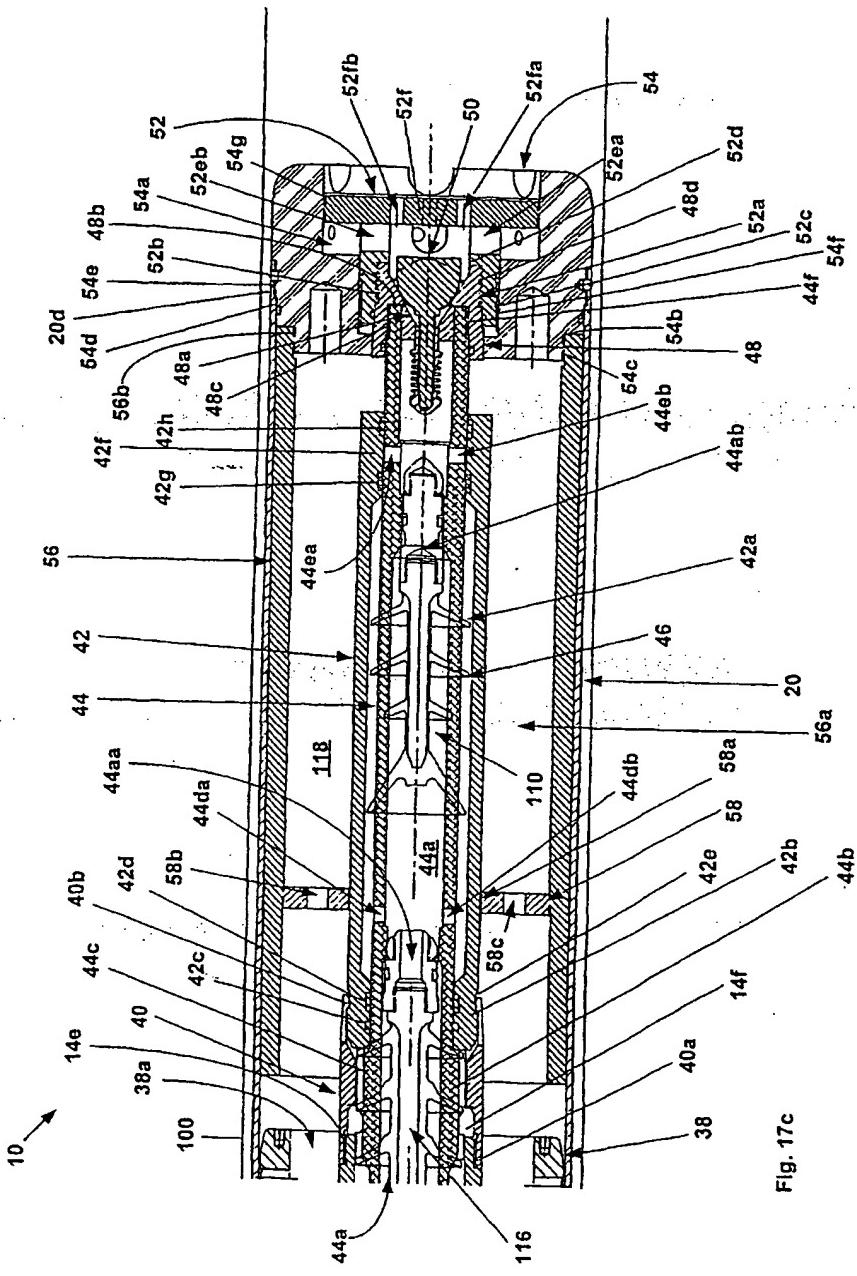


Fig. 17a





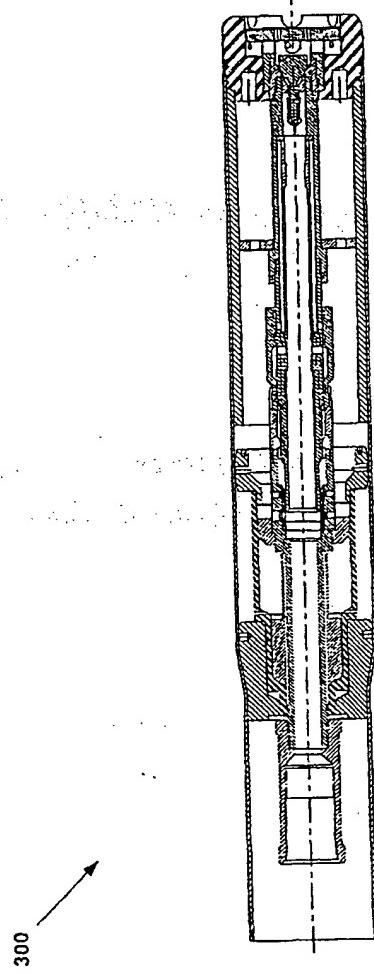


Fig. 18

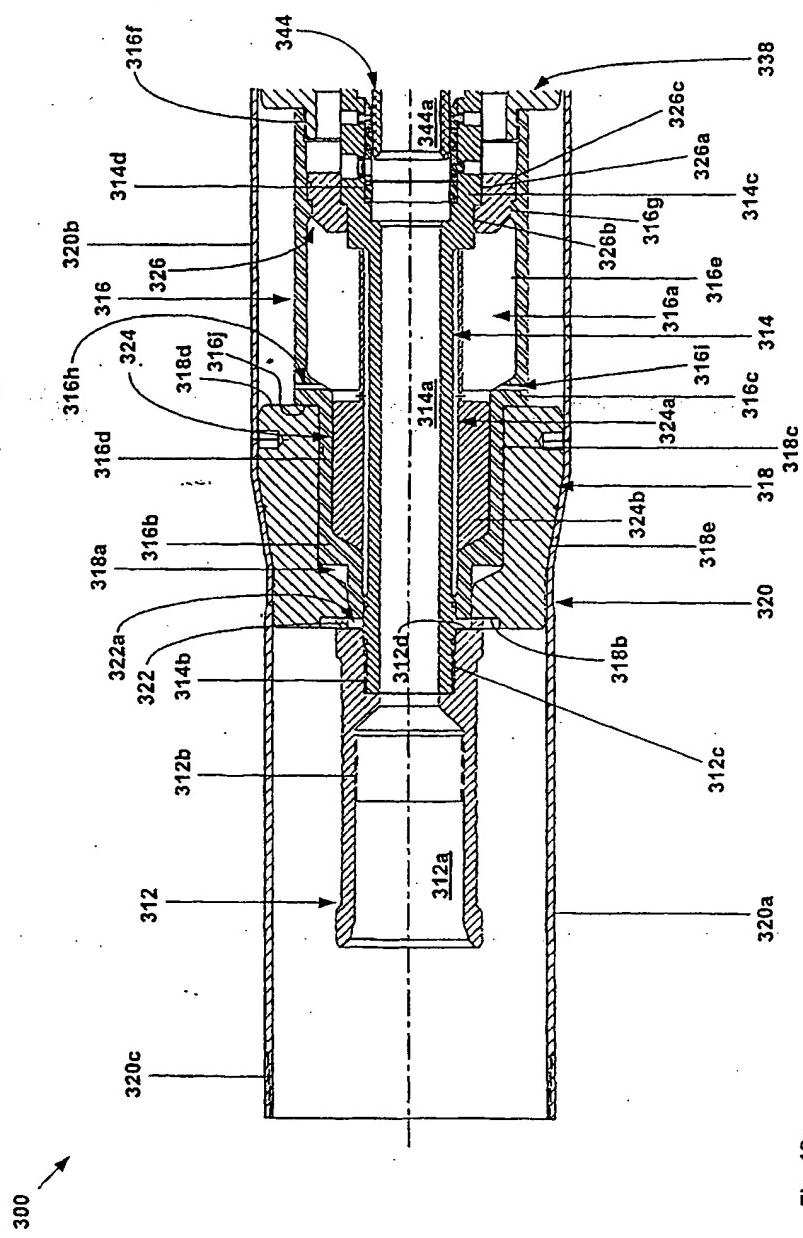
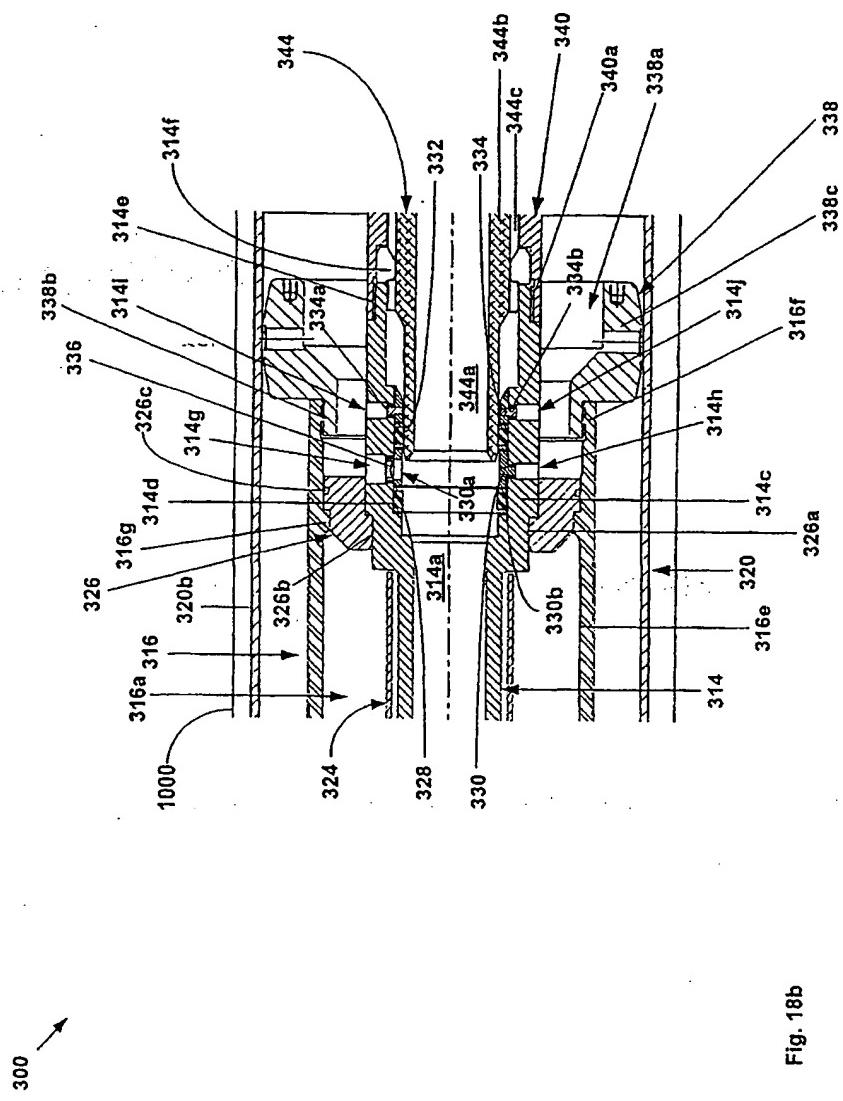


Fig. 18a



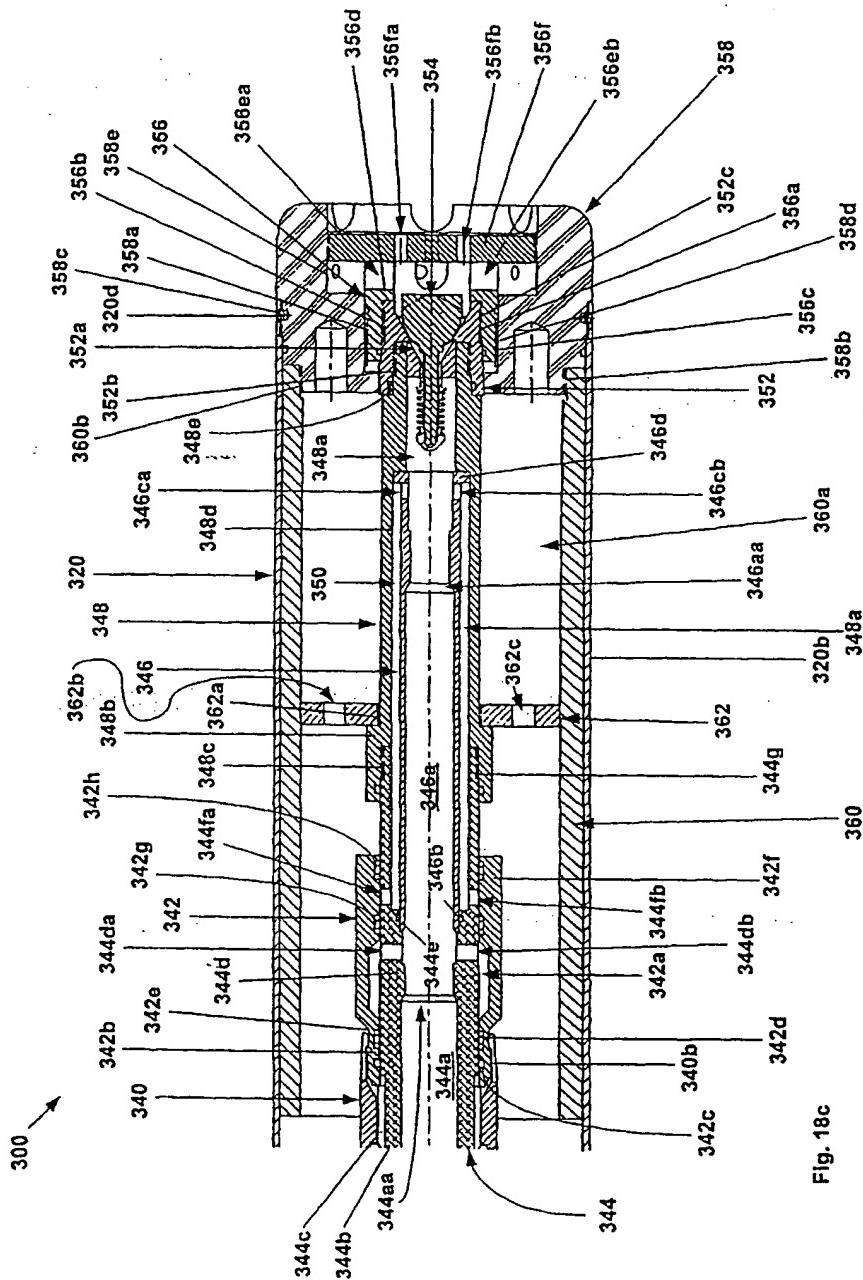


Fig. 18c

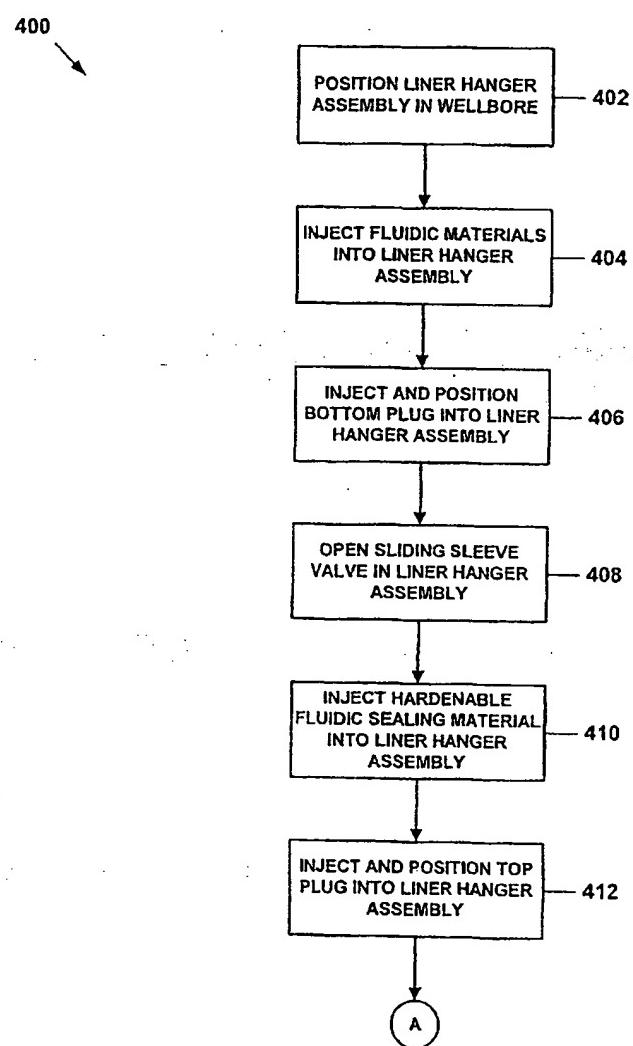


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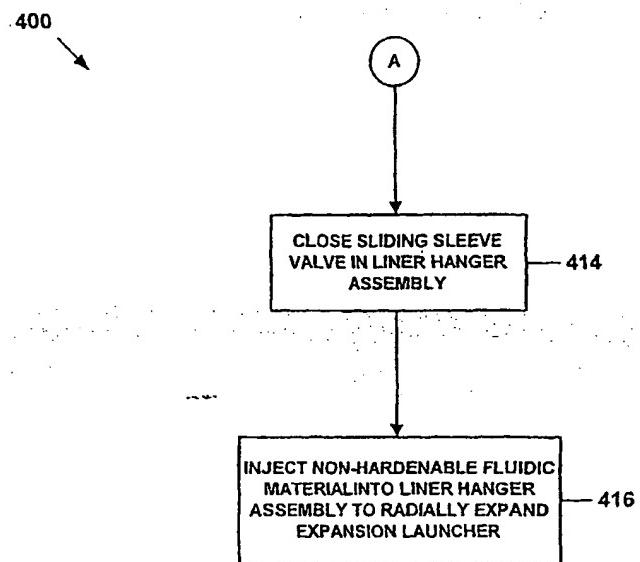


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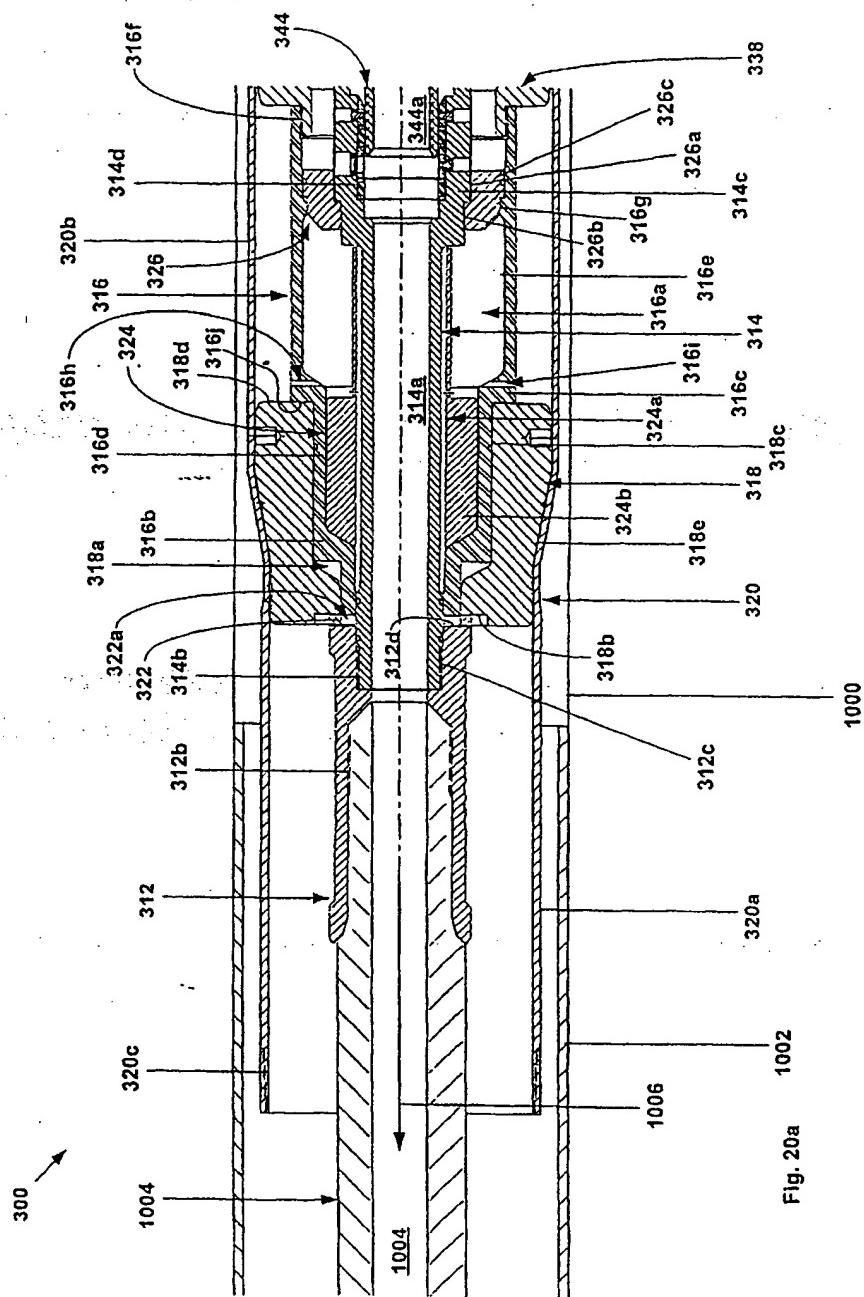


Fig. 20a

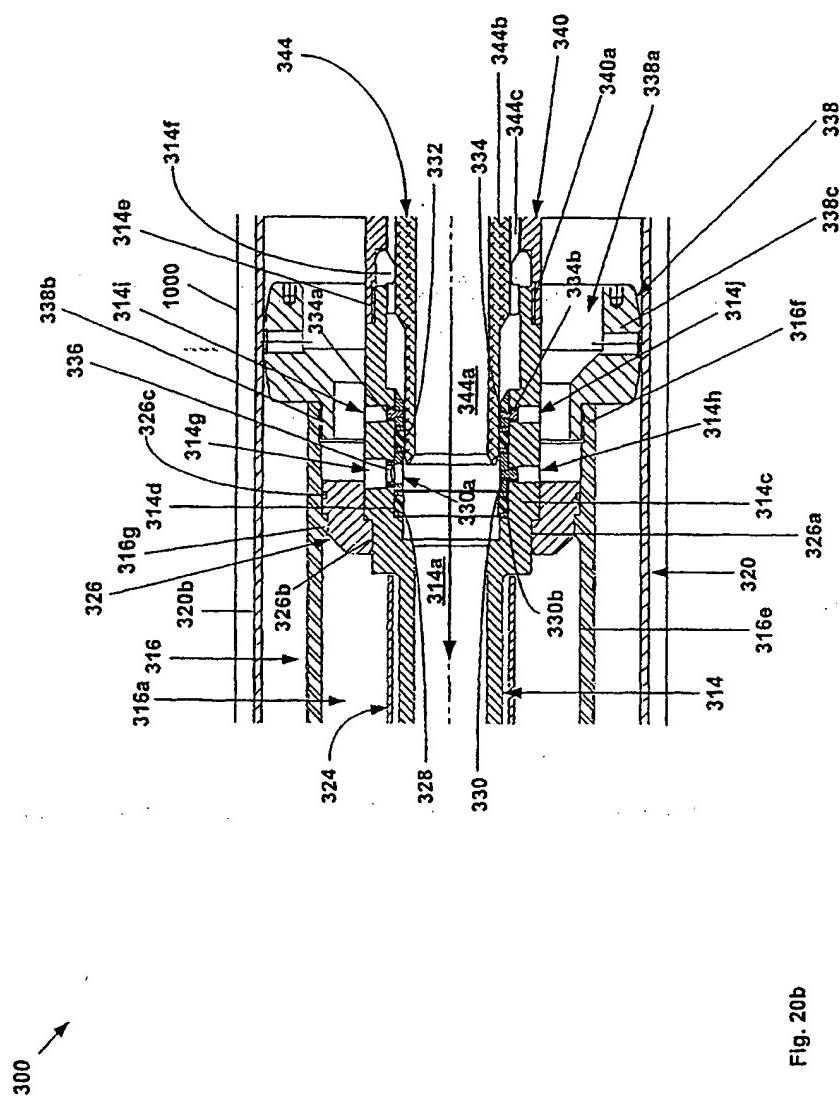


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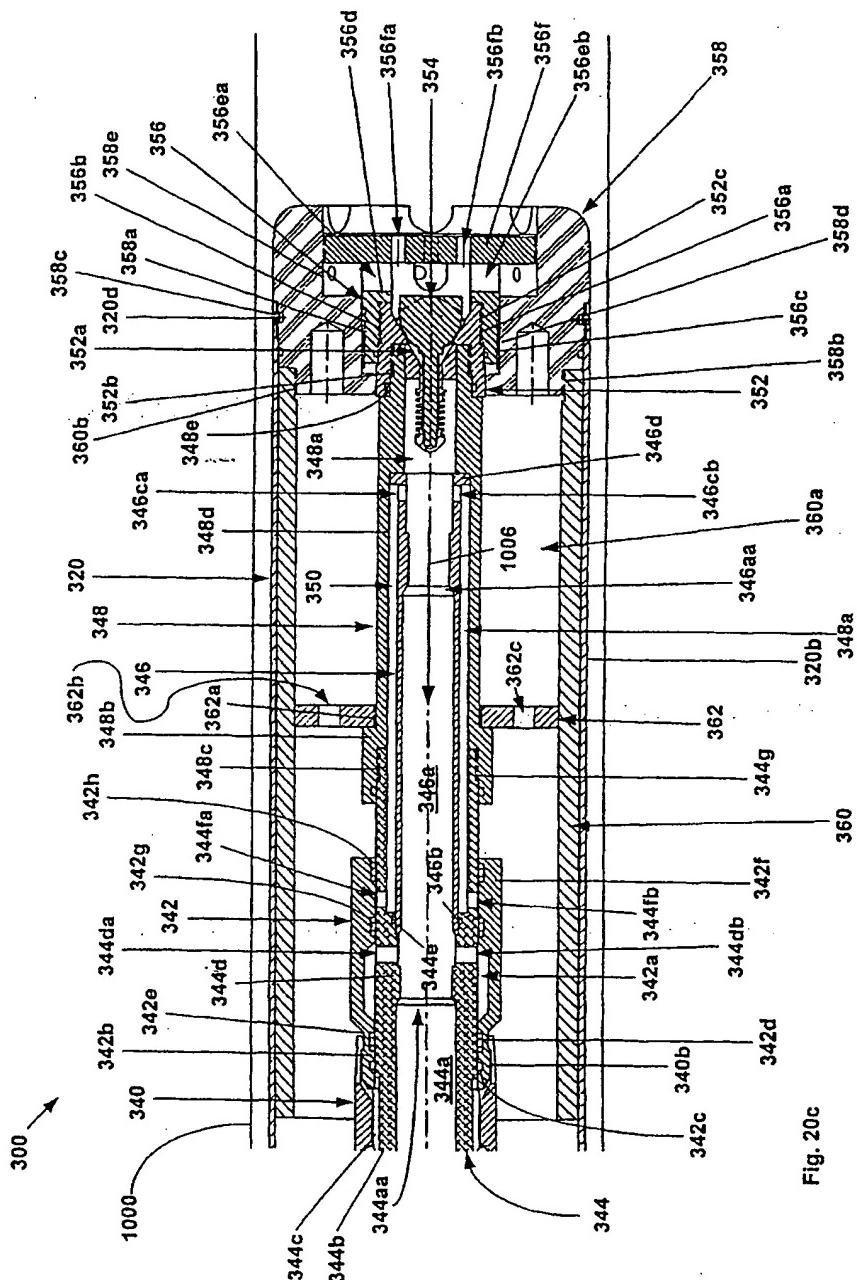


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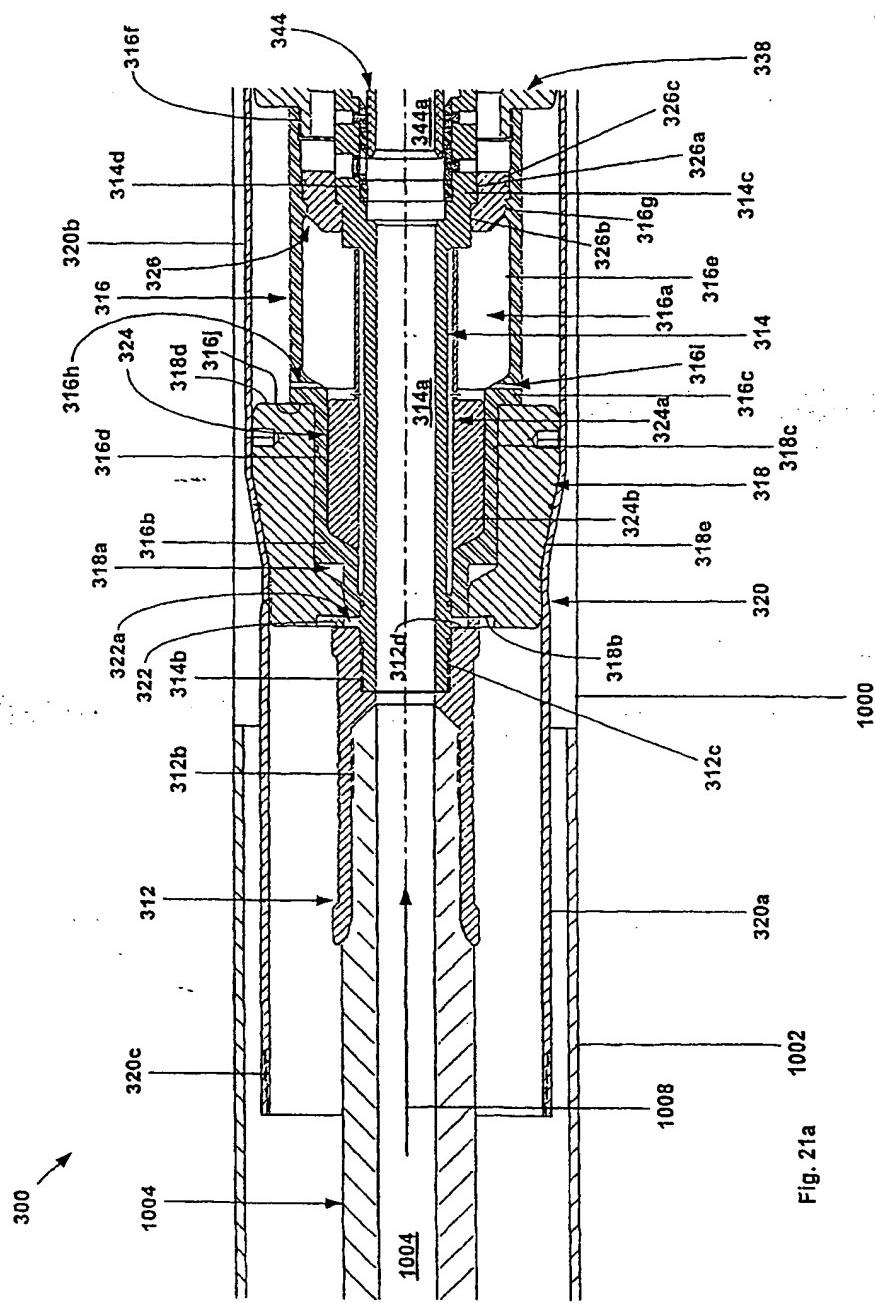


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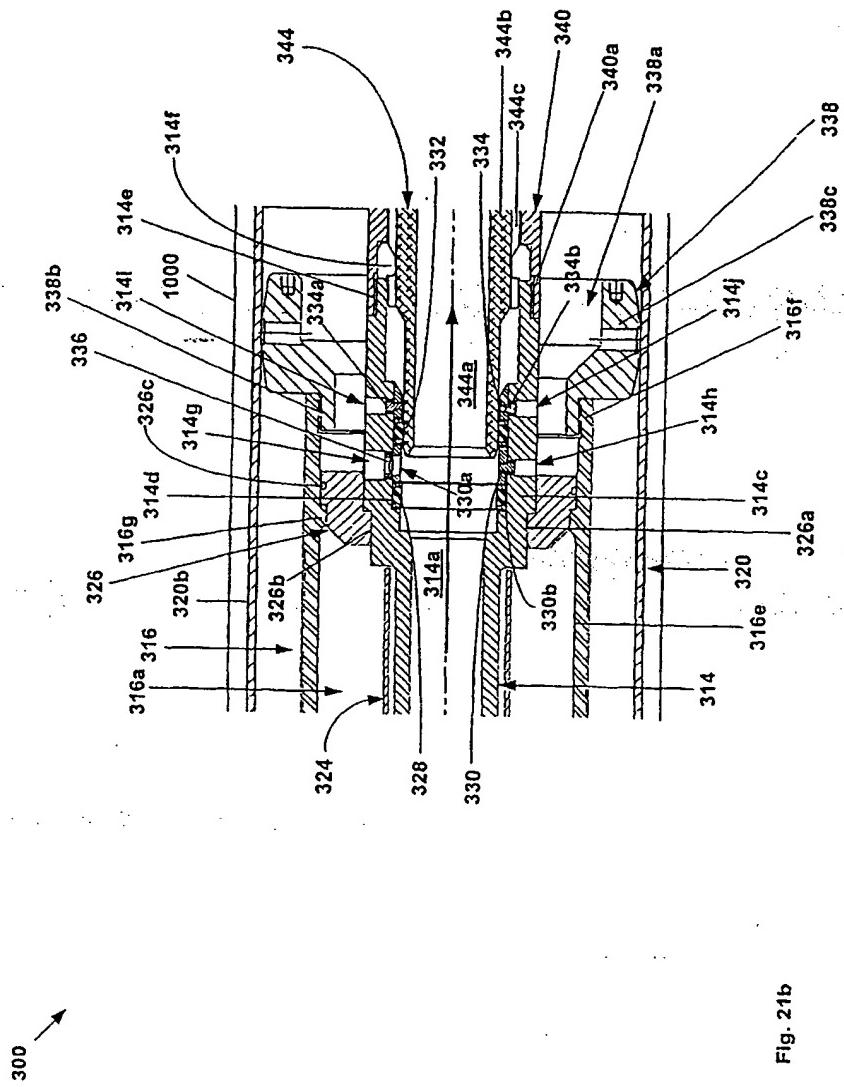


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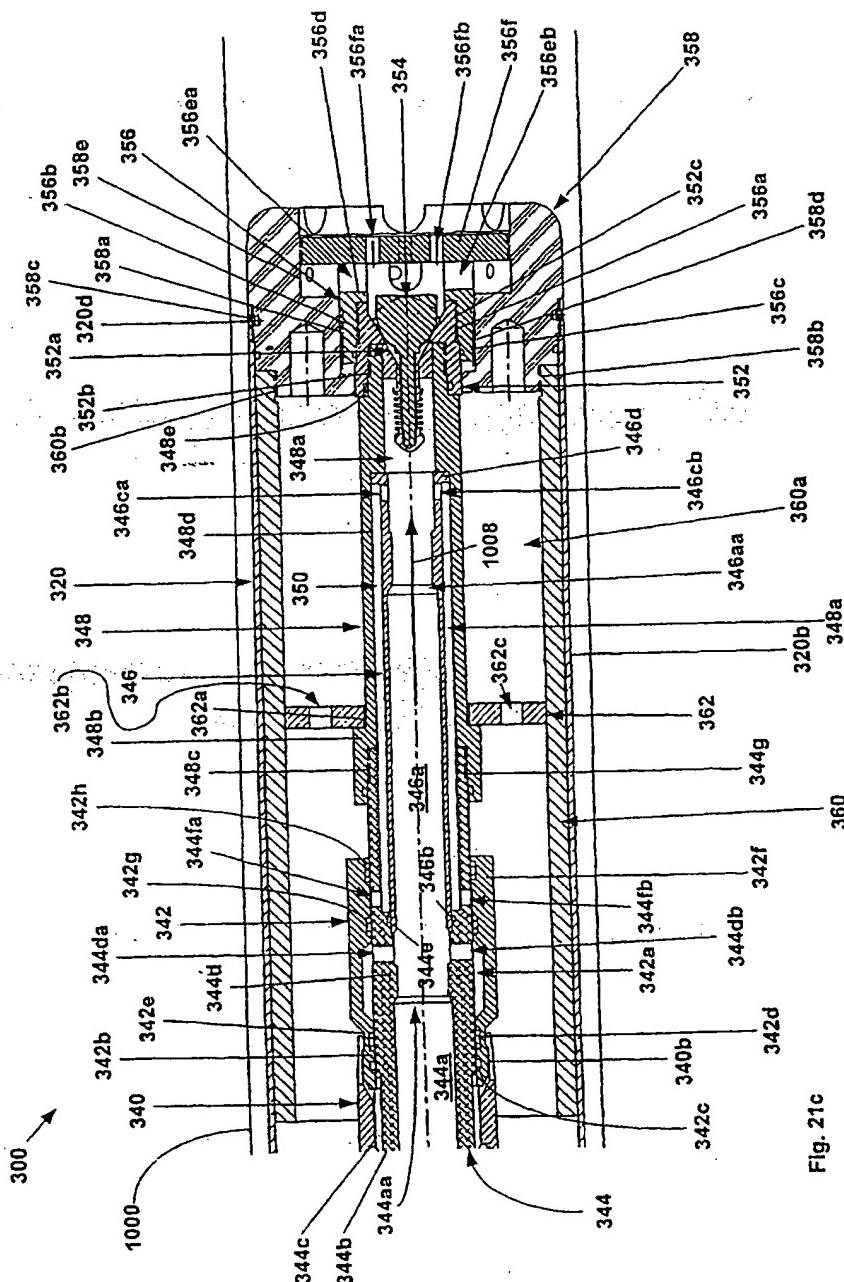


Fig. 21c

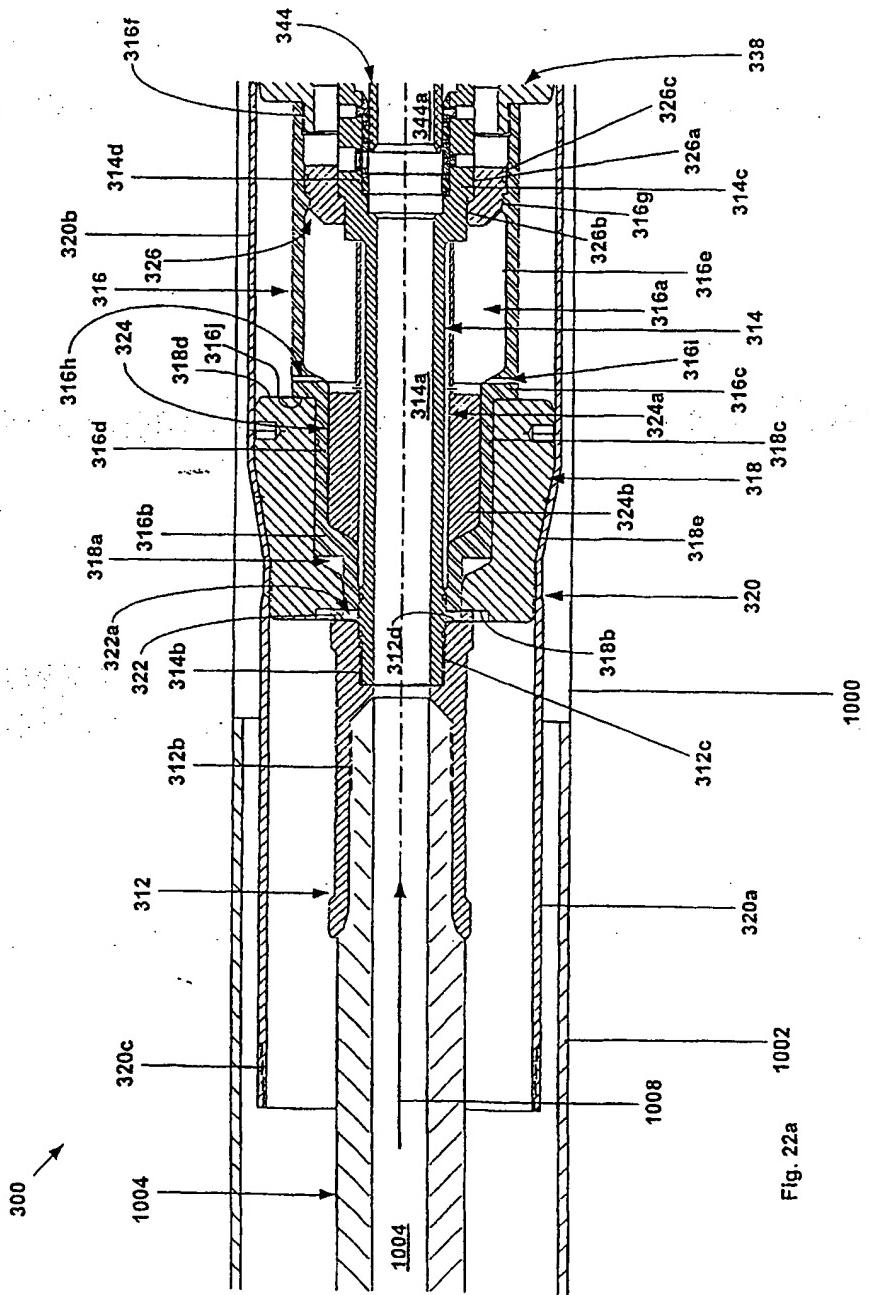


Fig. 22a 1002

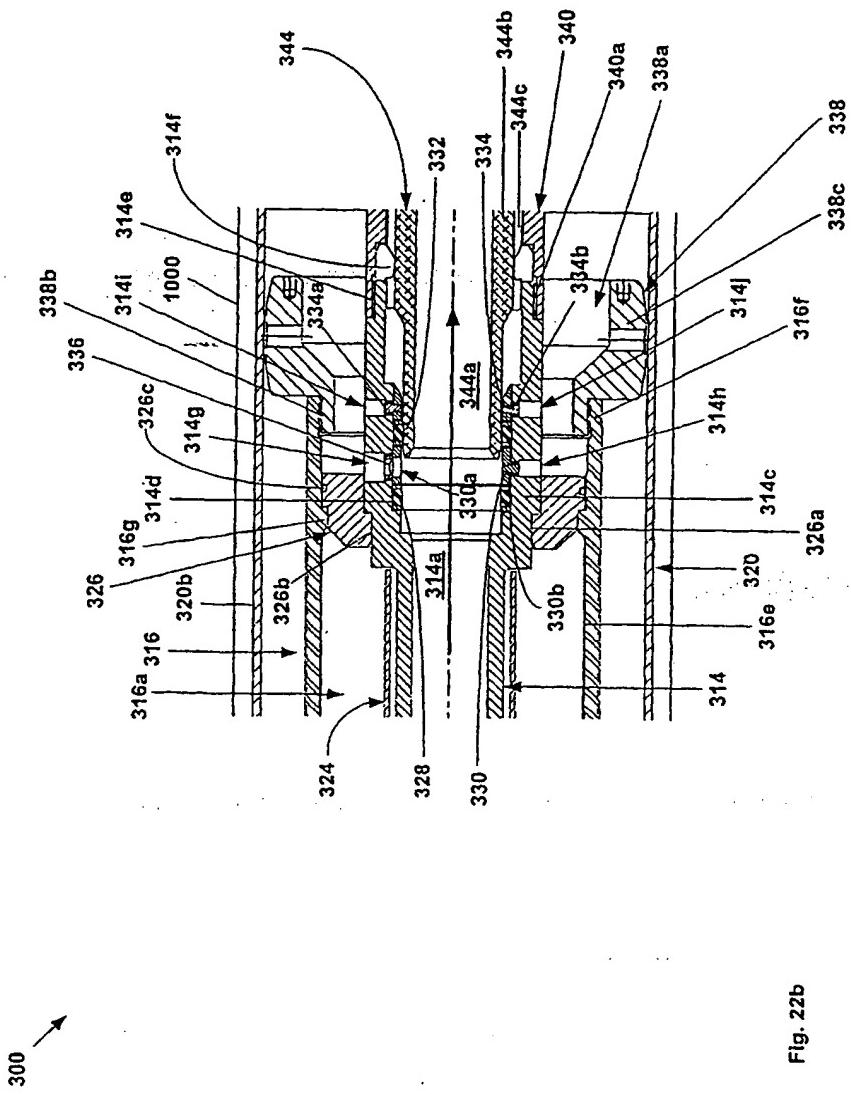


Fig. 22b

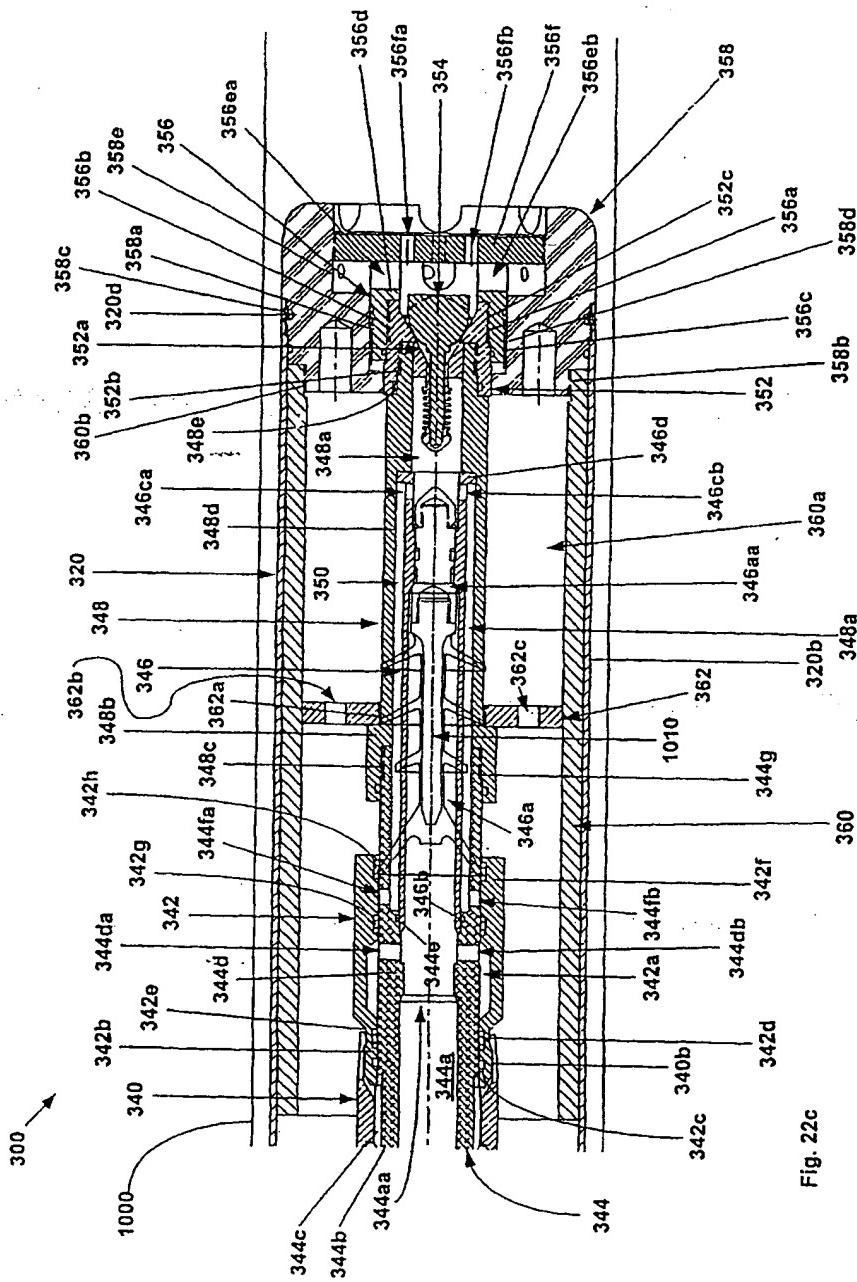
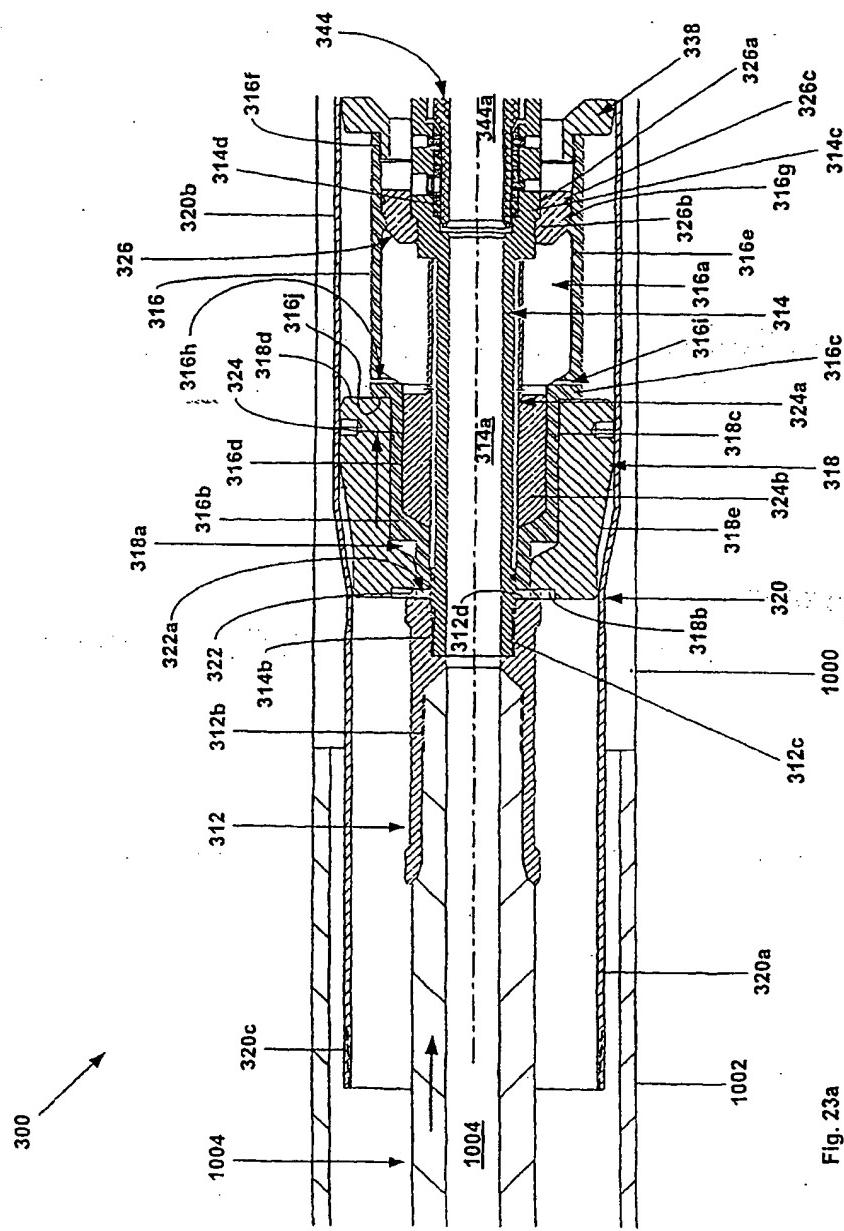


Fig. 22c



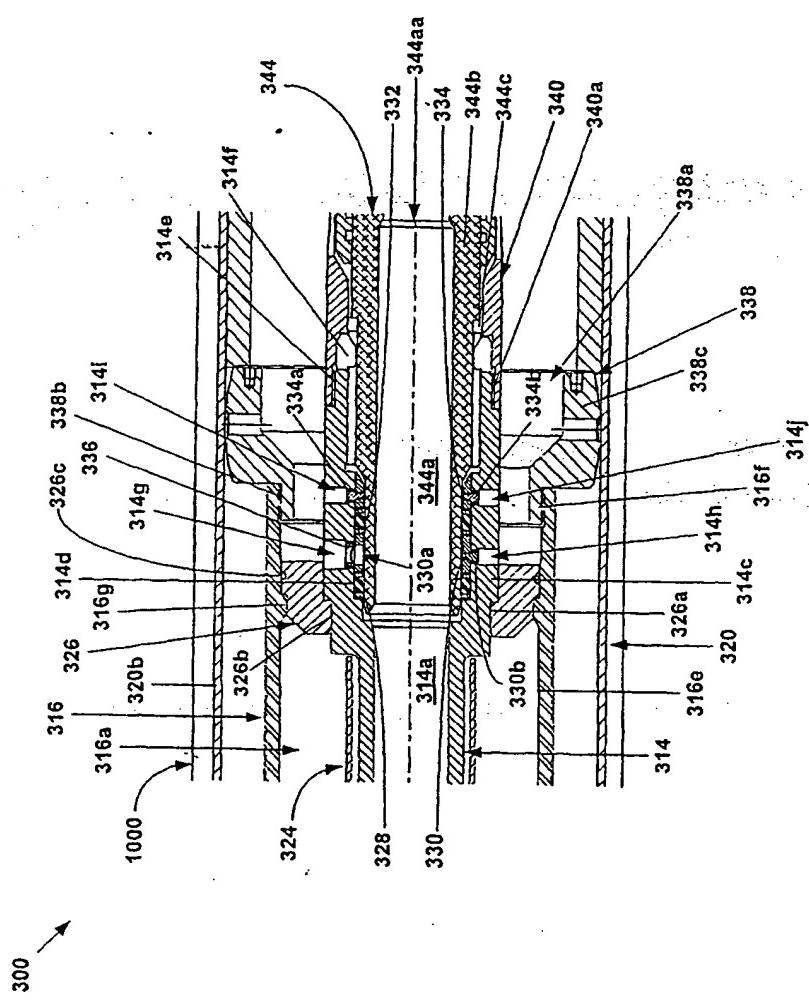


Fig. 23b

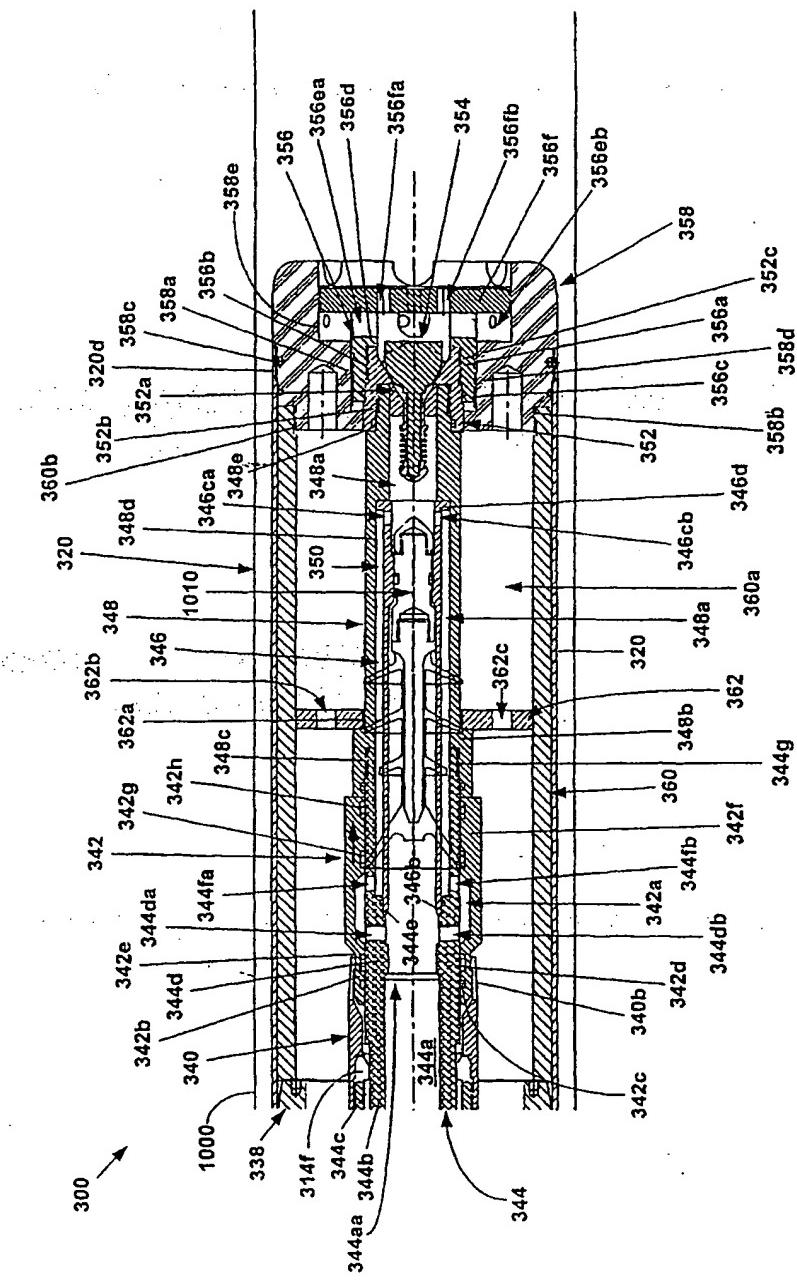
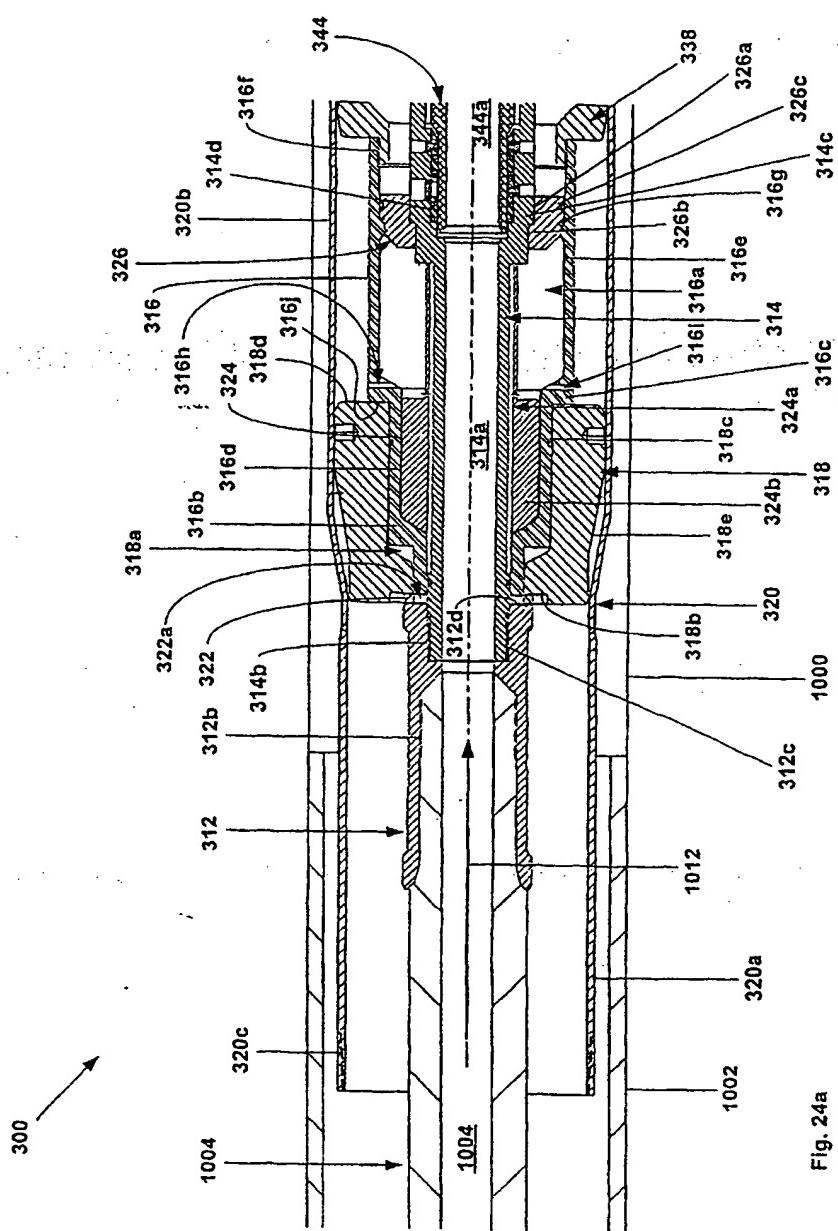


Fig. 23c



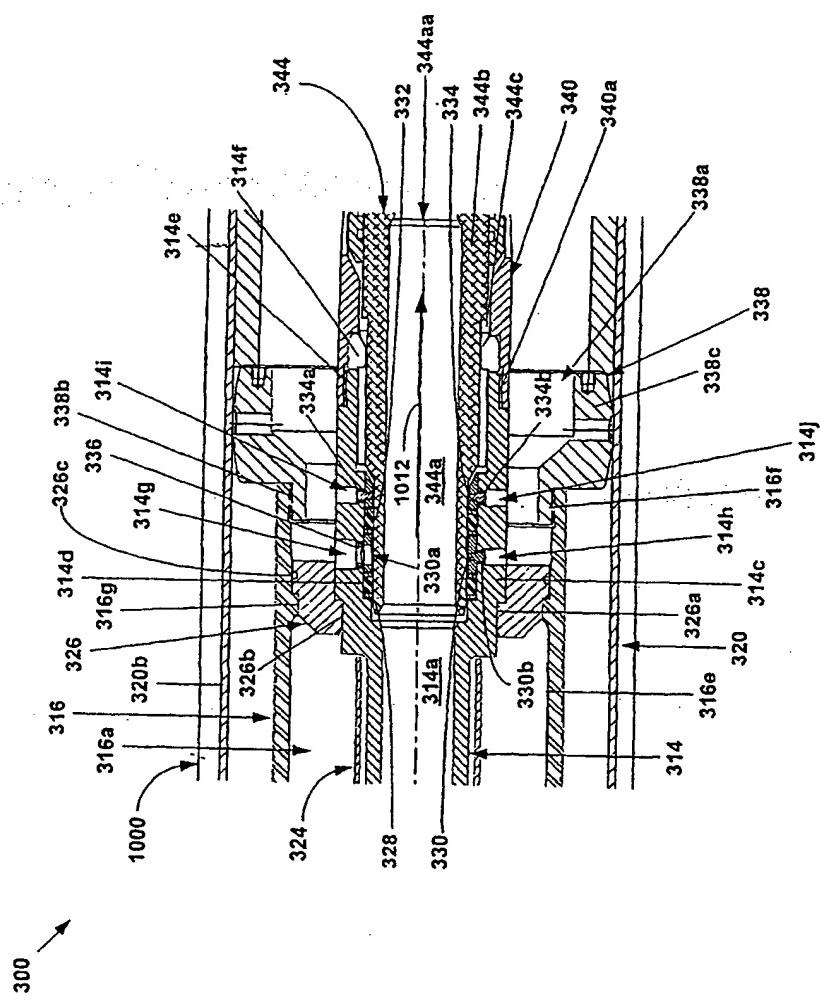


Fig. 24b

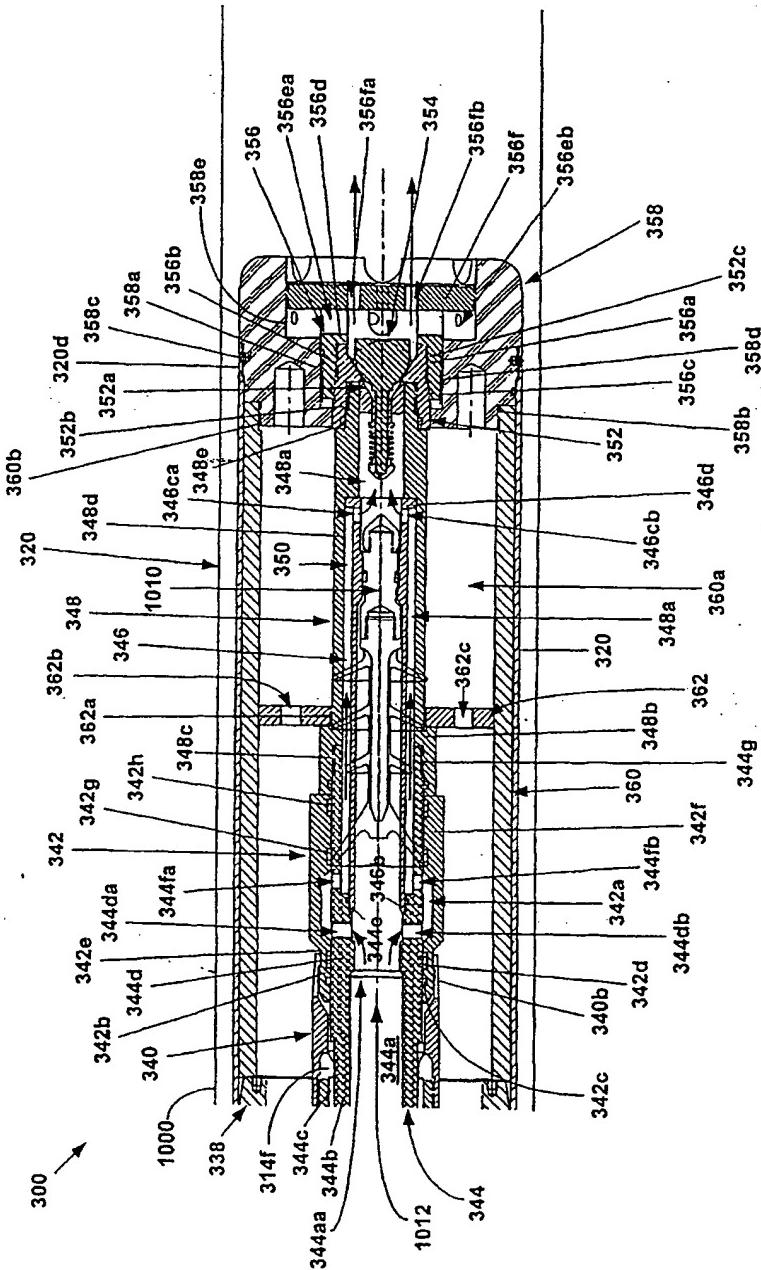


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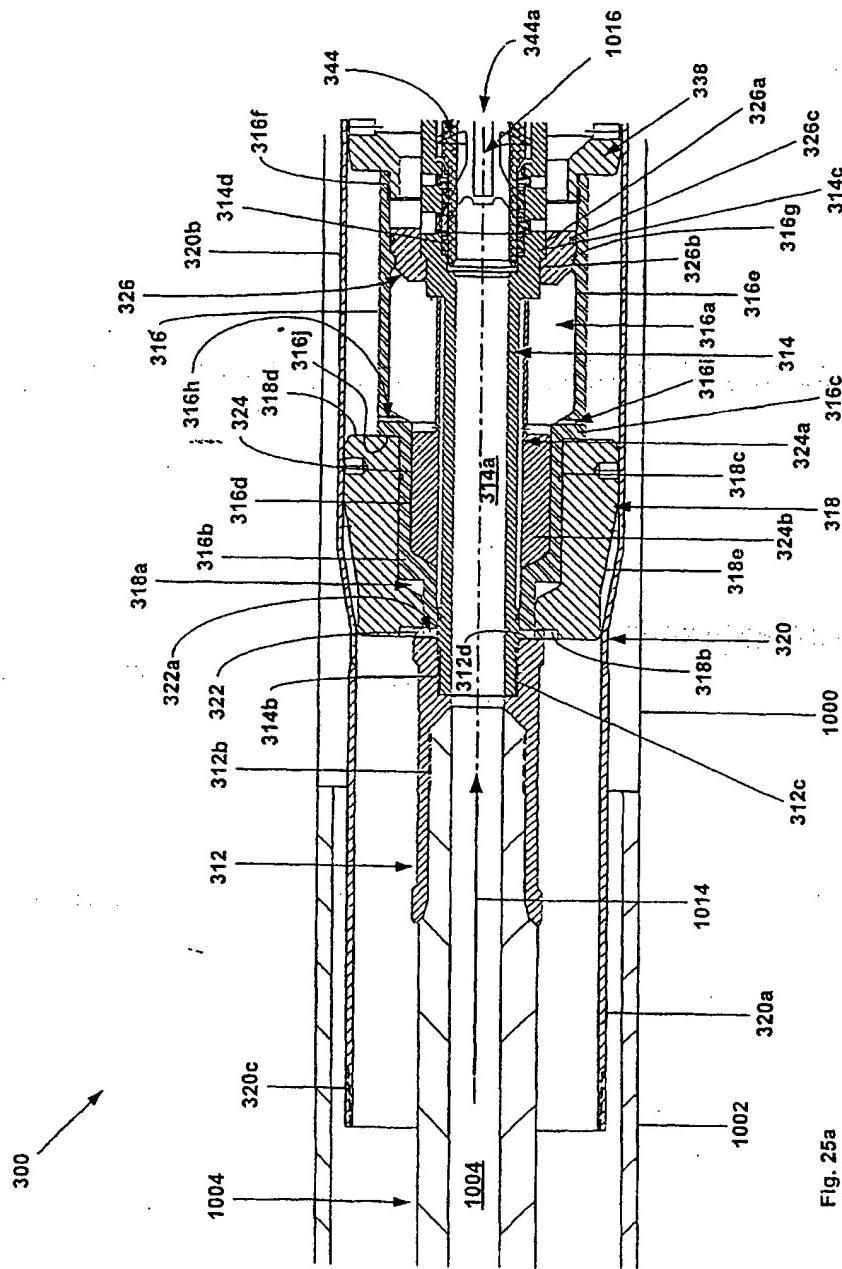


Fig. 25a

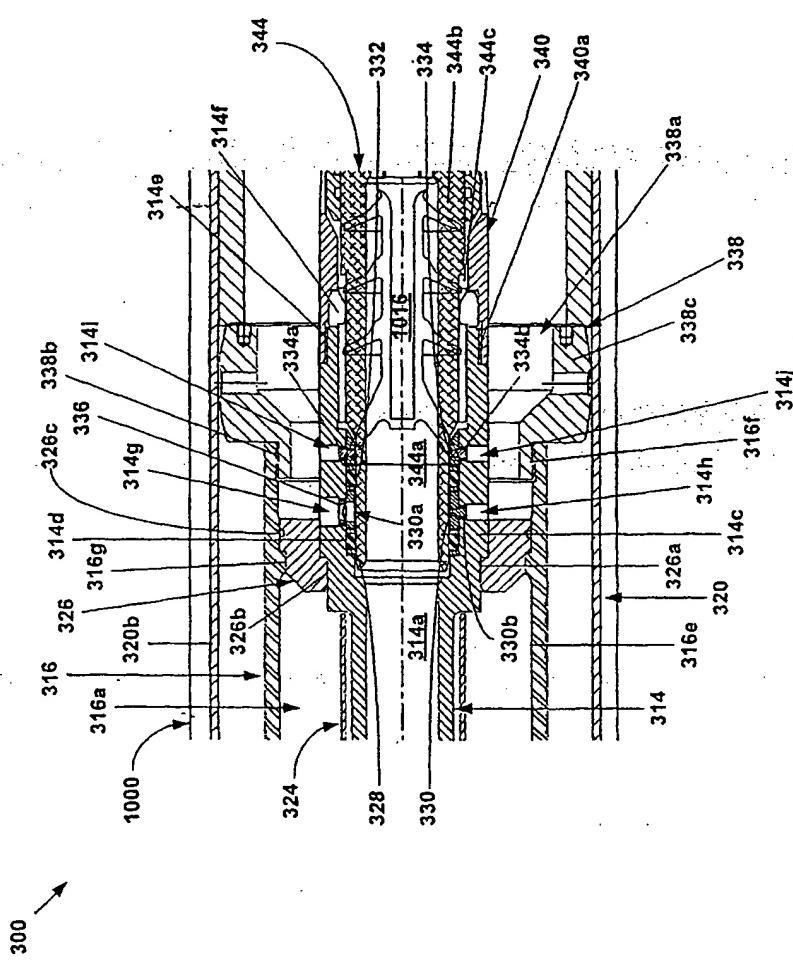


Fig. 25b

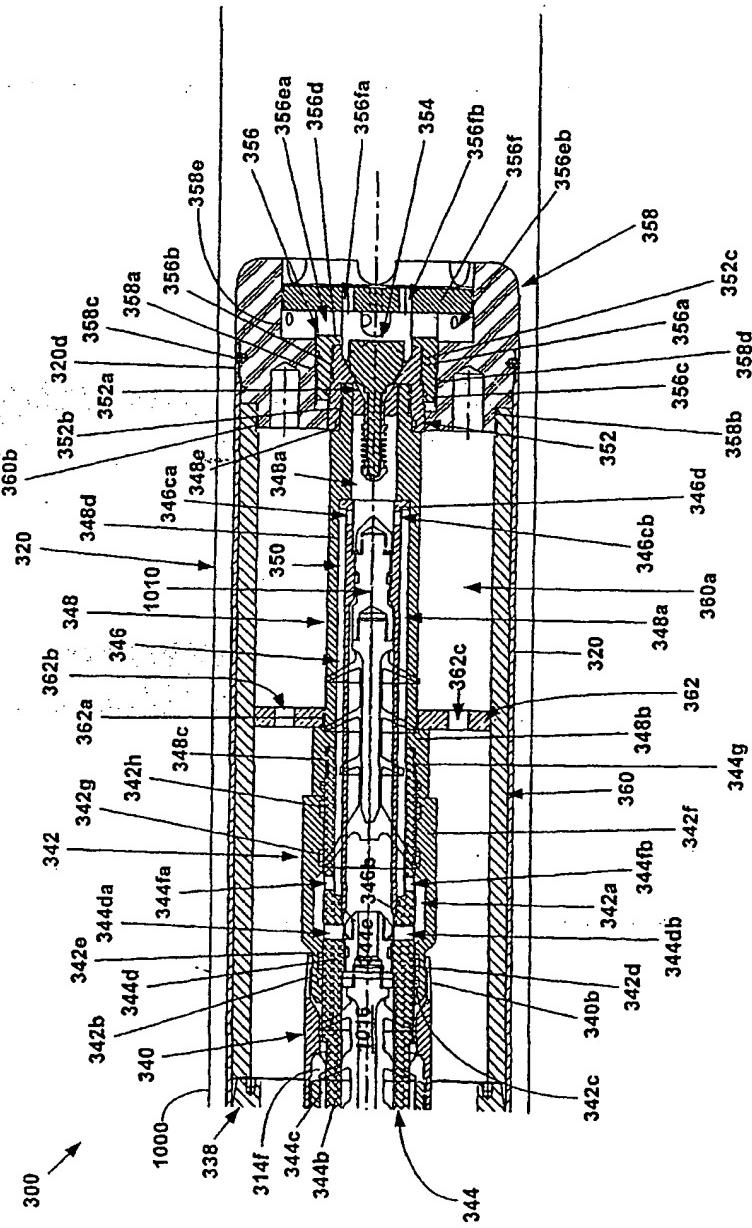


Fig. 25c

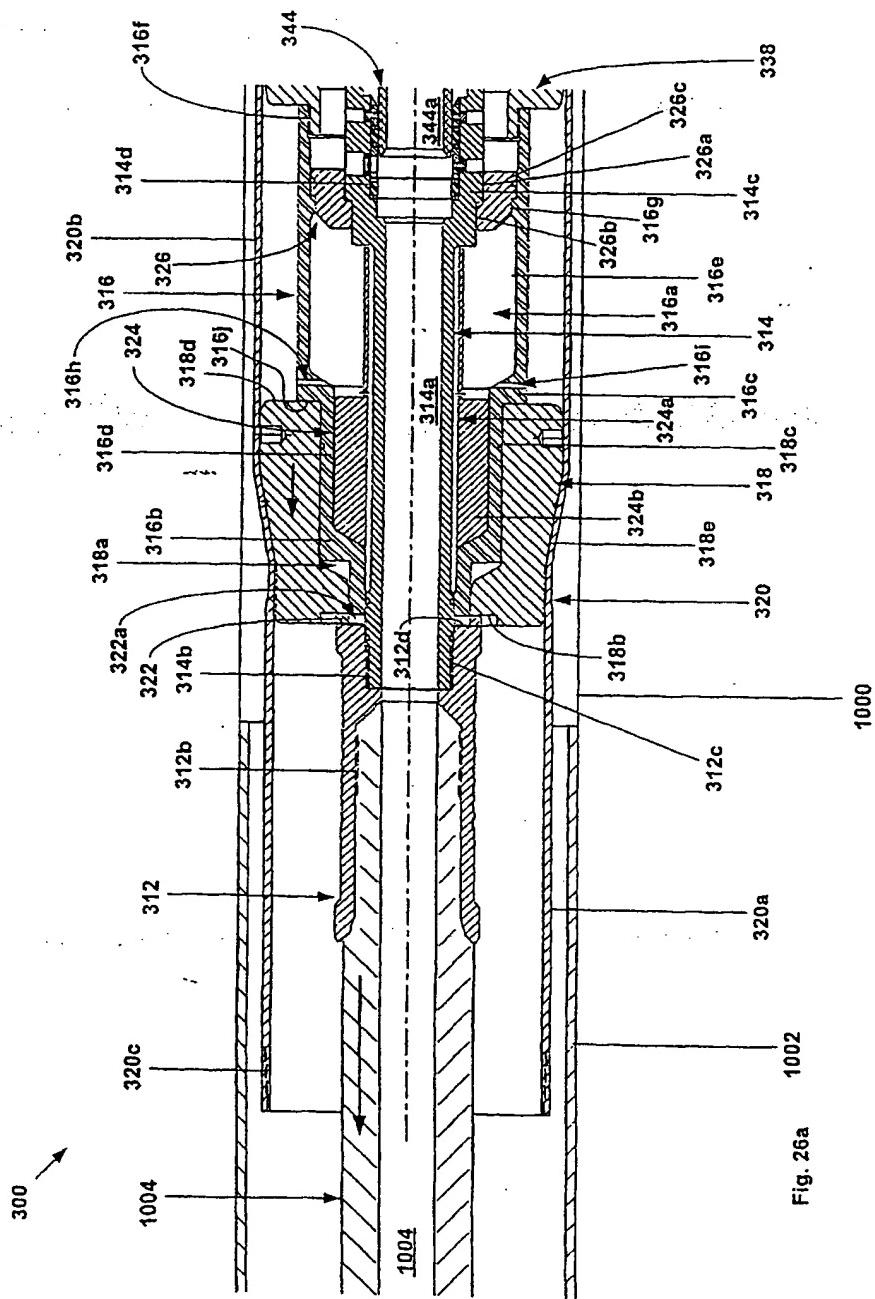


Fig. 26a 1002

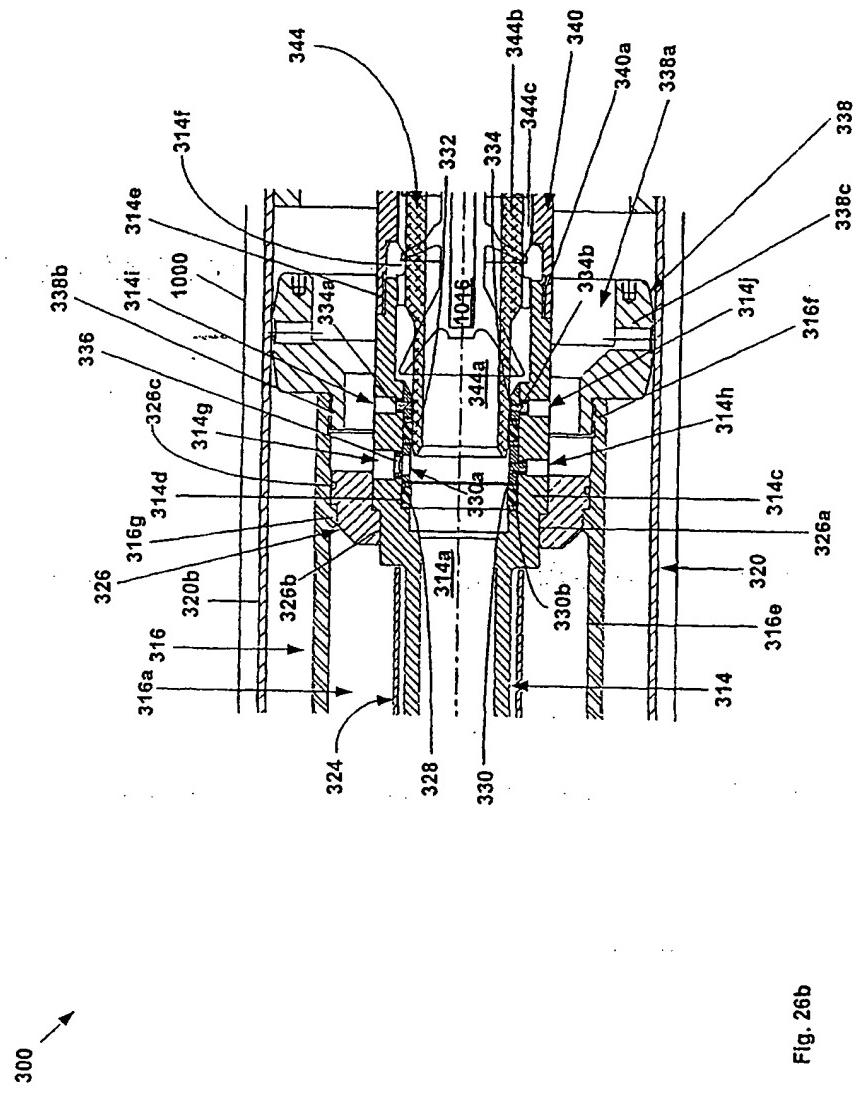
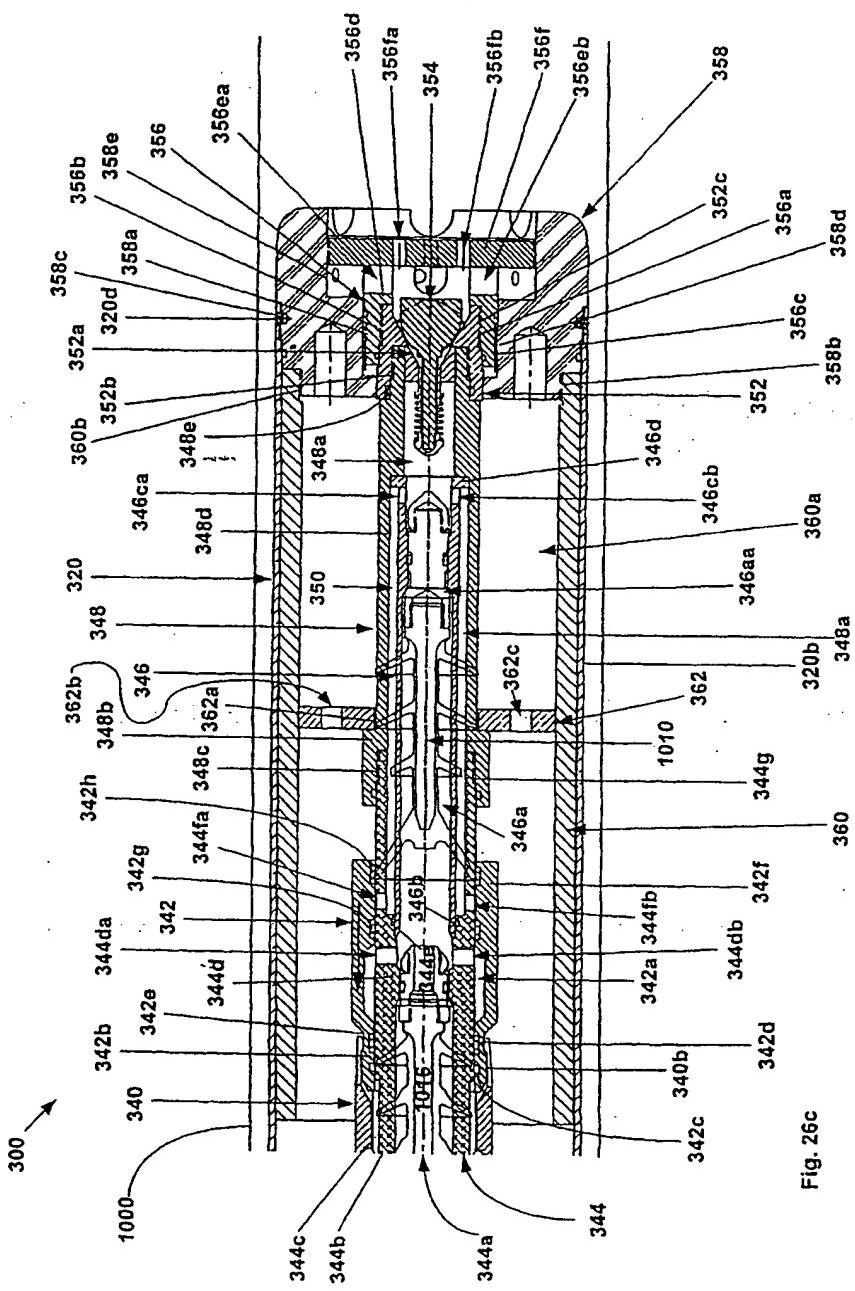


Fig. 26b



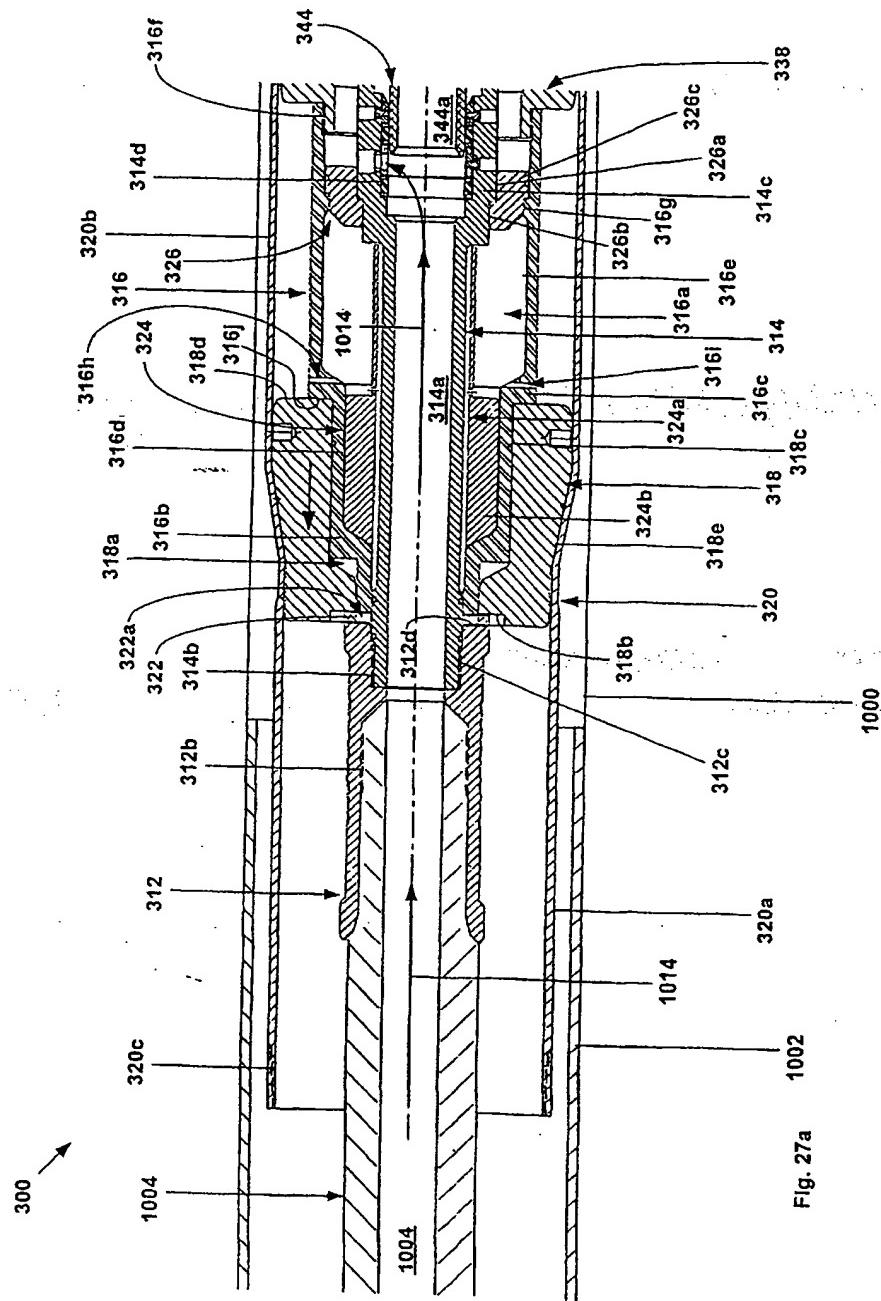
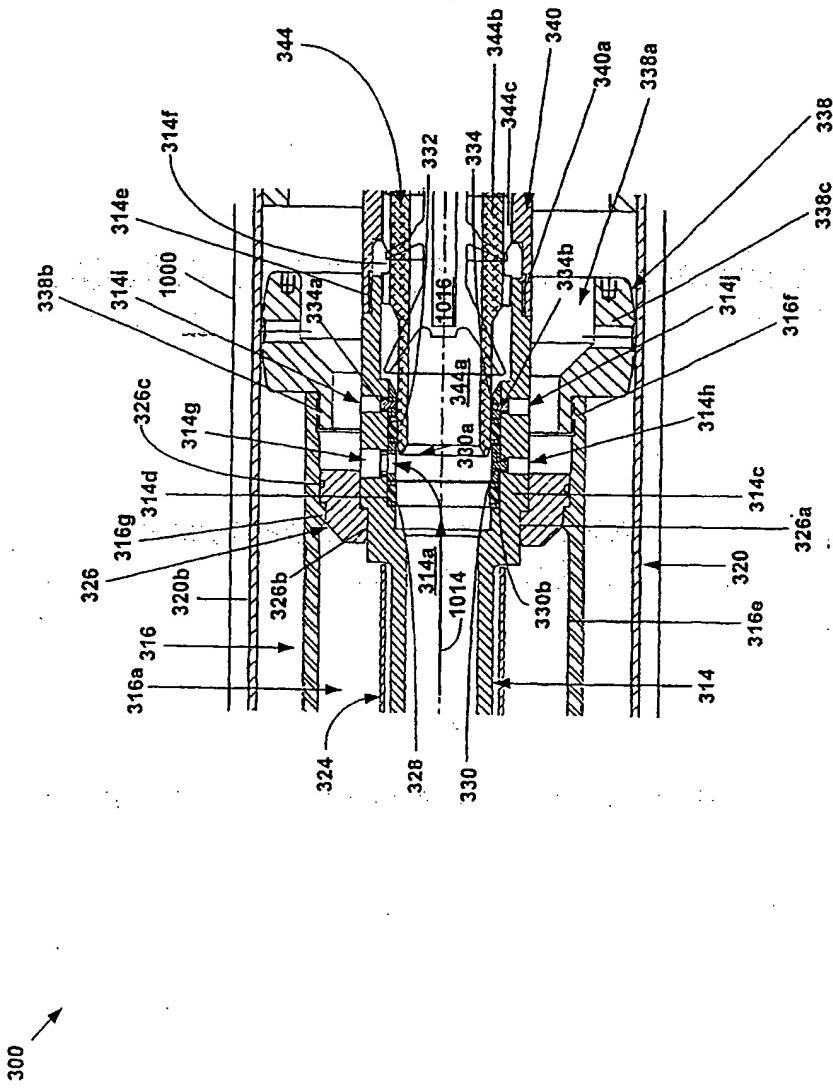


Fig. 27a



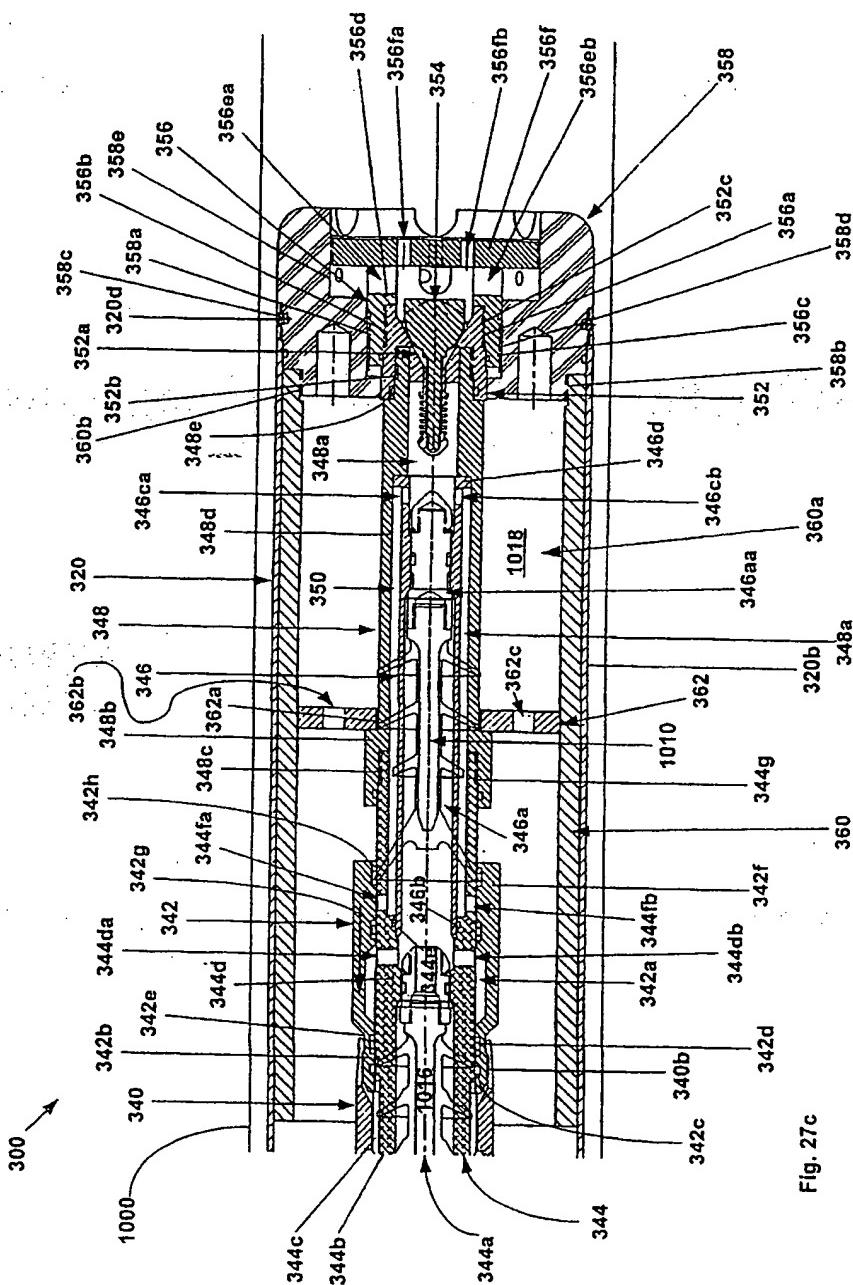


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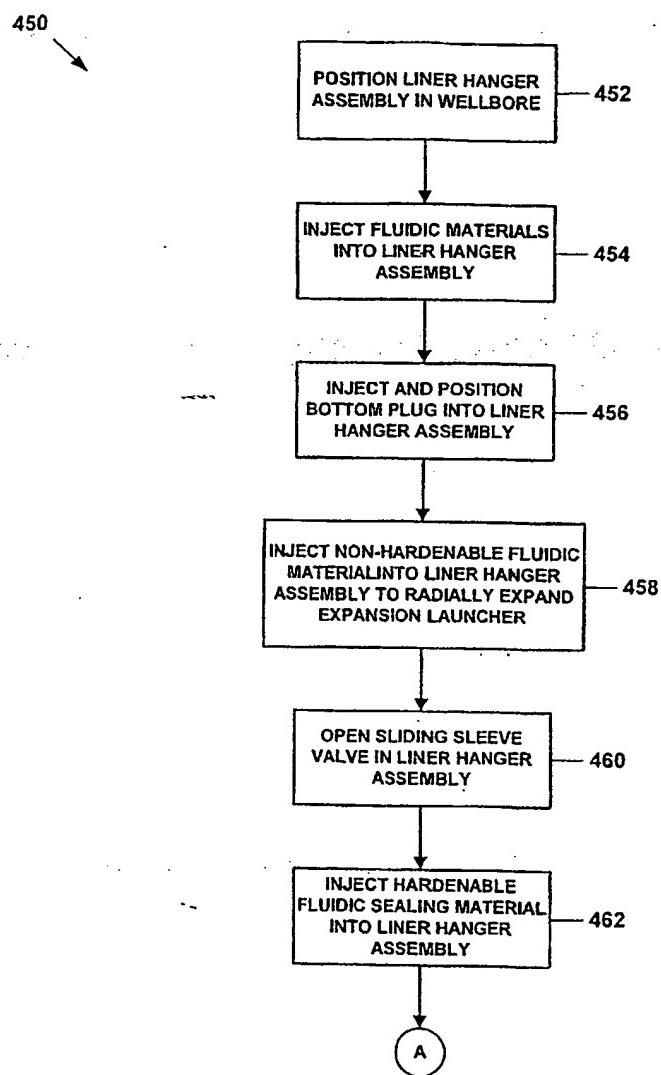


Fig. 28a

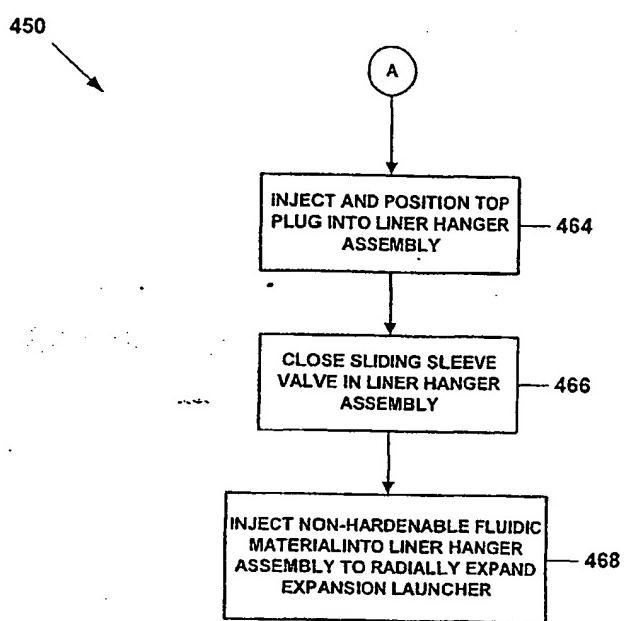


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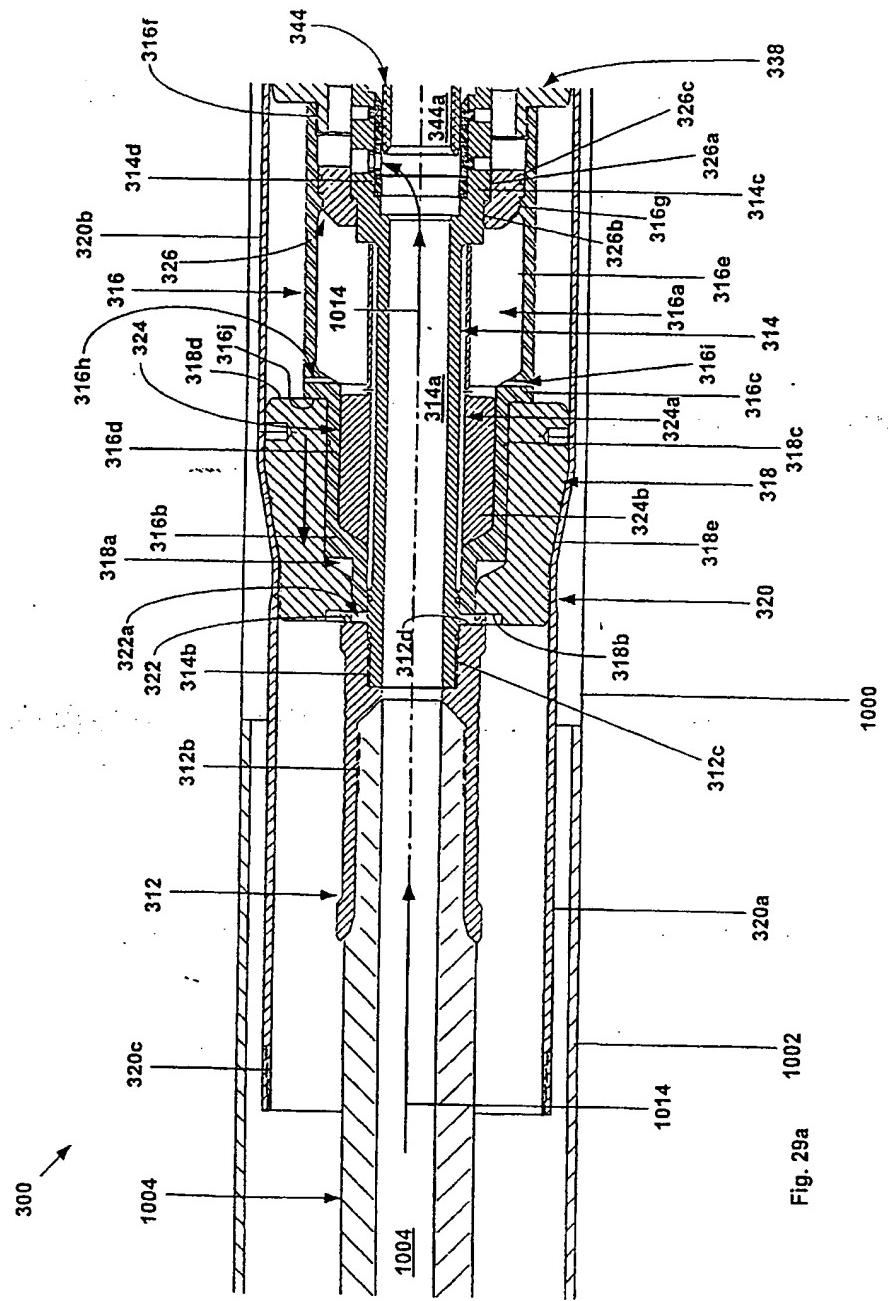


Fig. 29a

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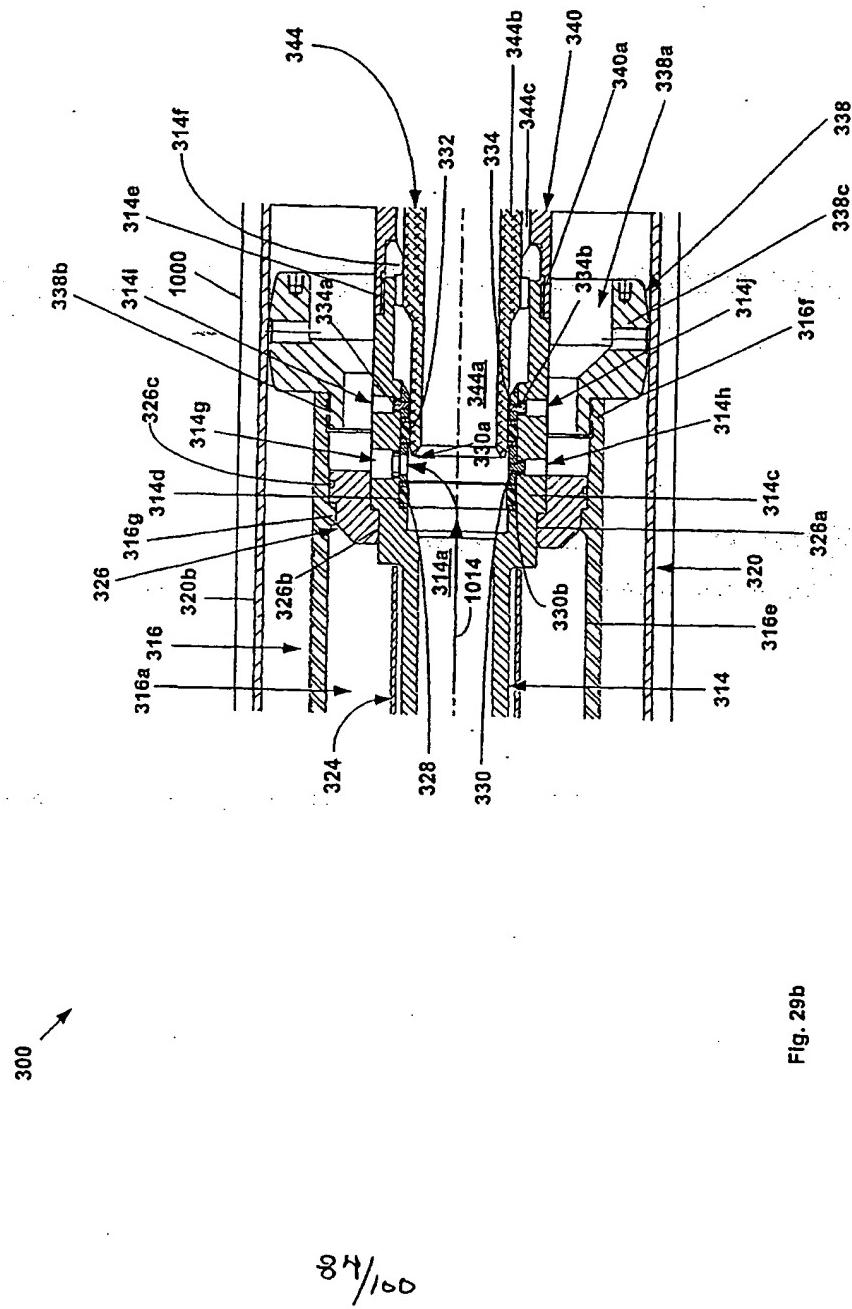


Fig. 29b

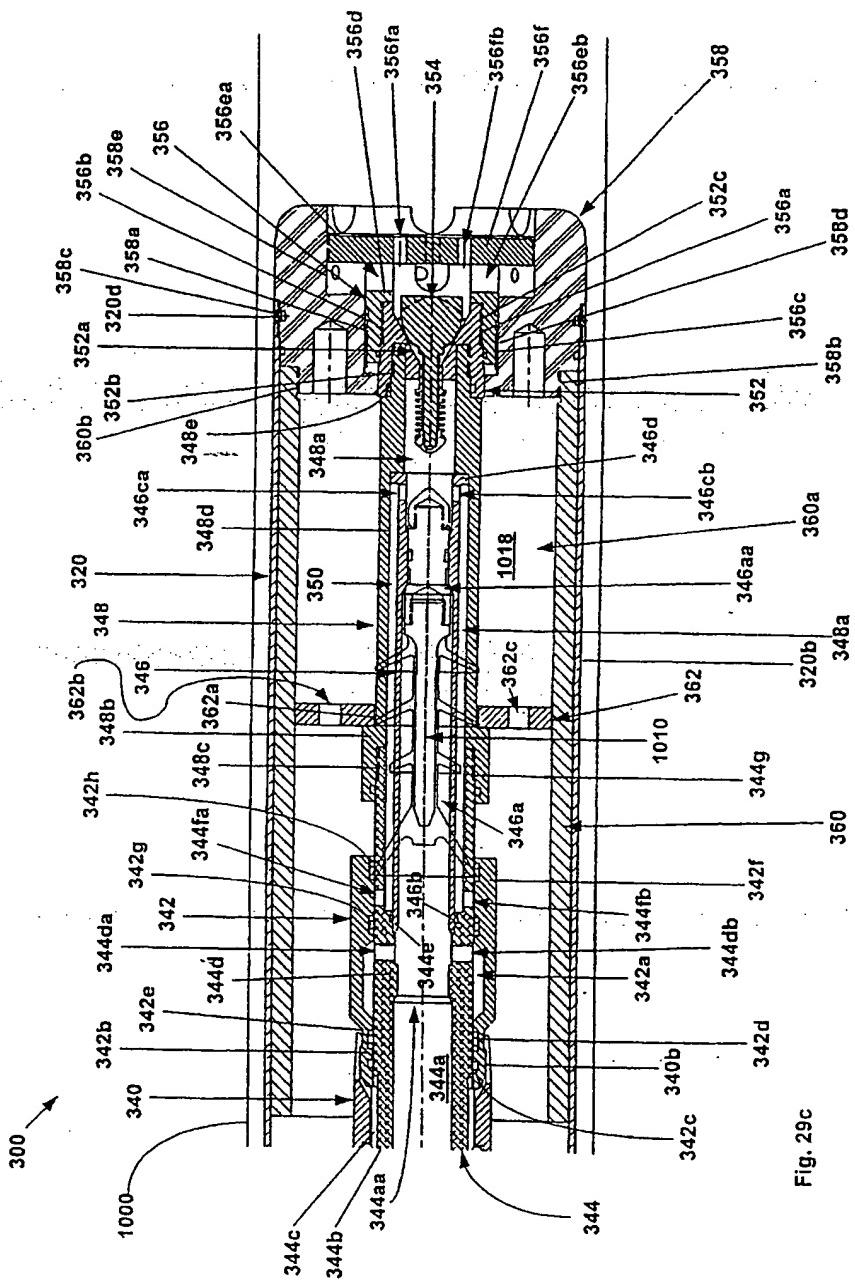


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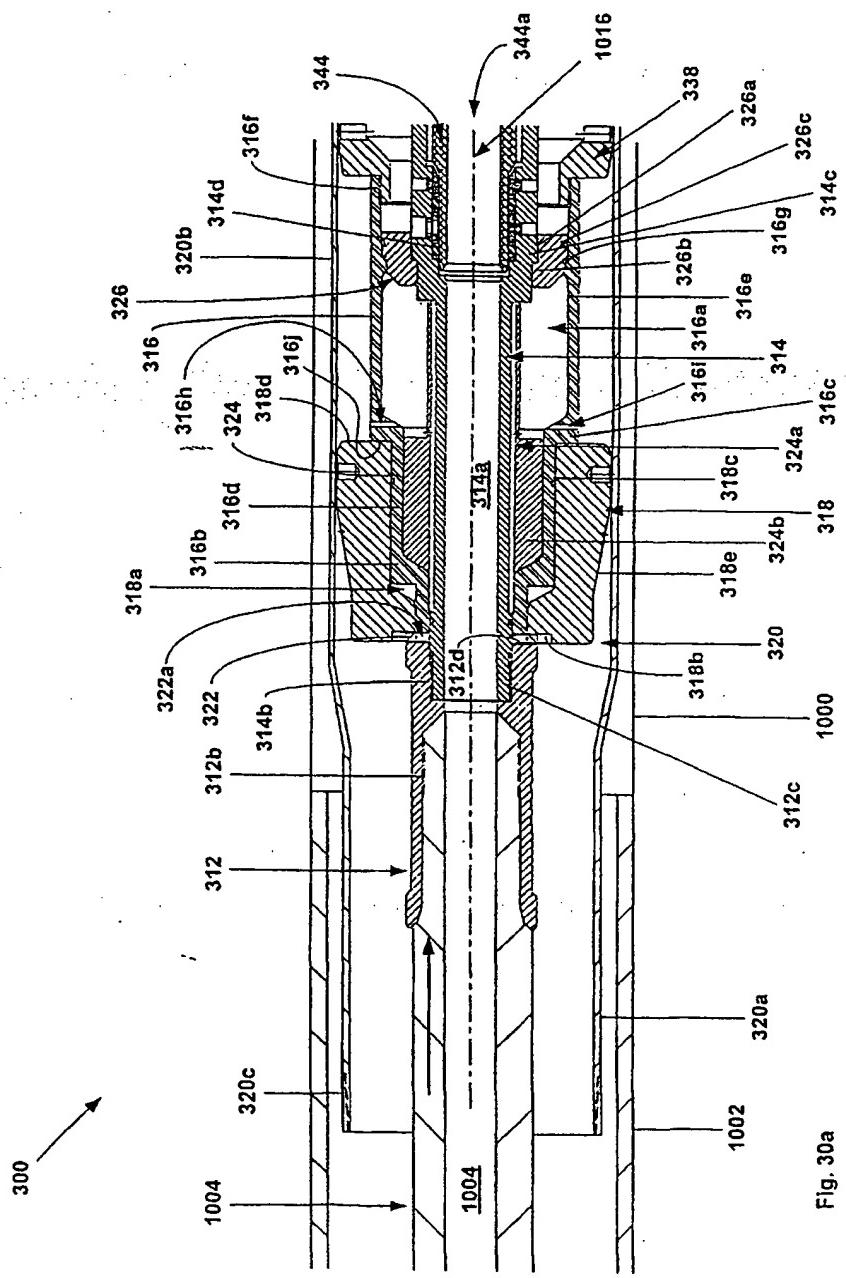


Fig. 30a

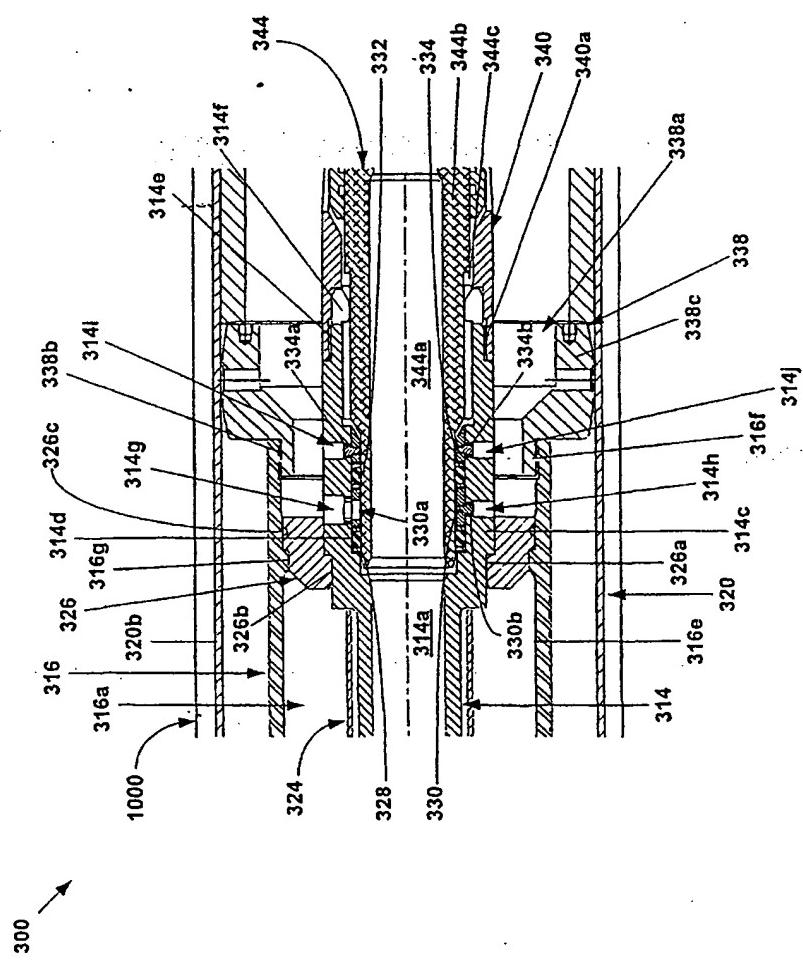


Fig. 30b

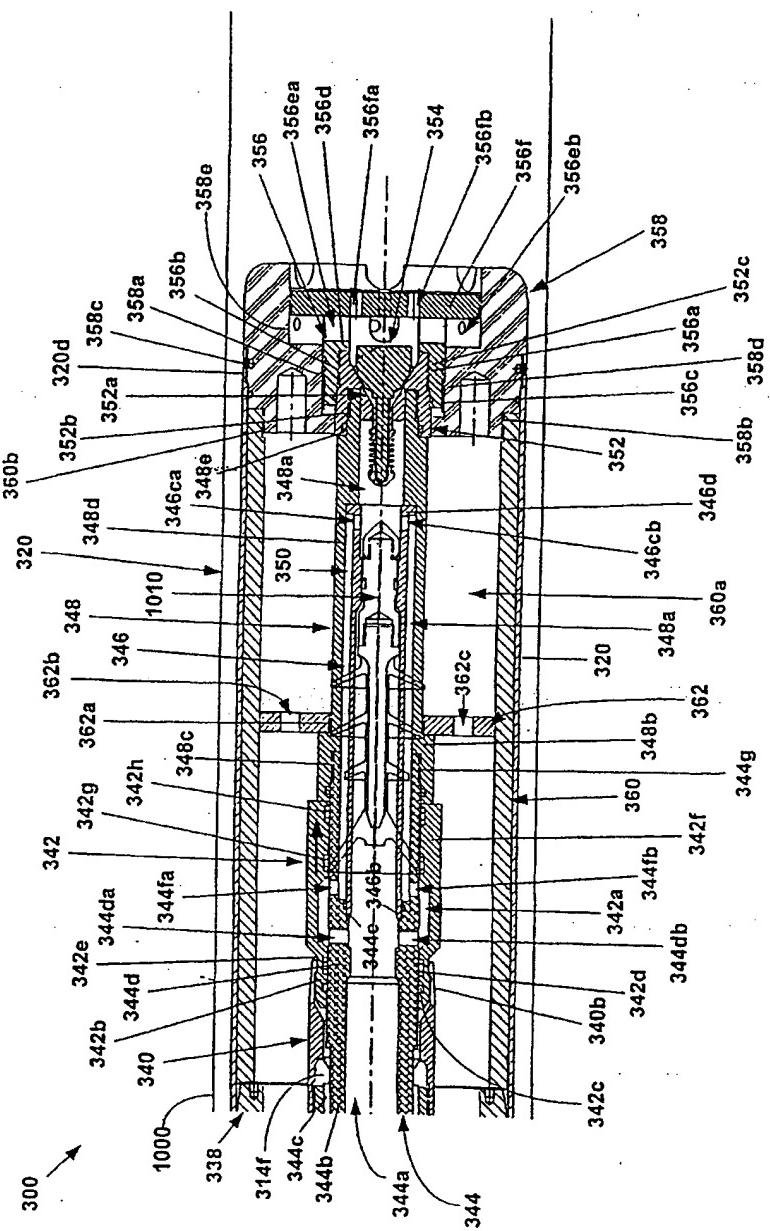


Fig. 30c

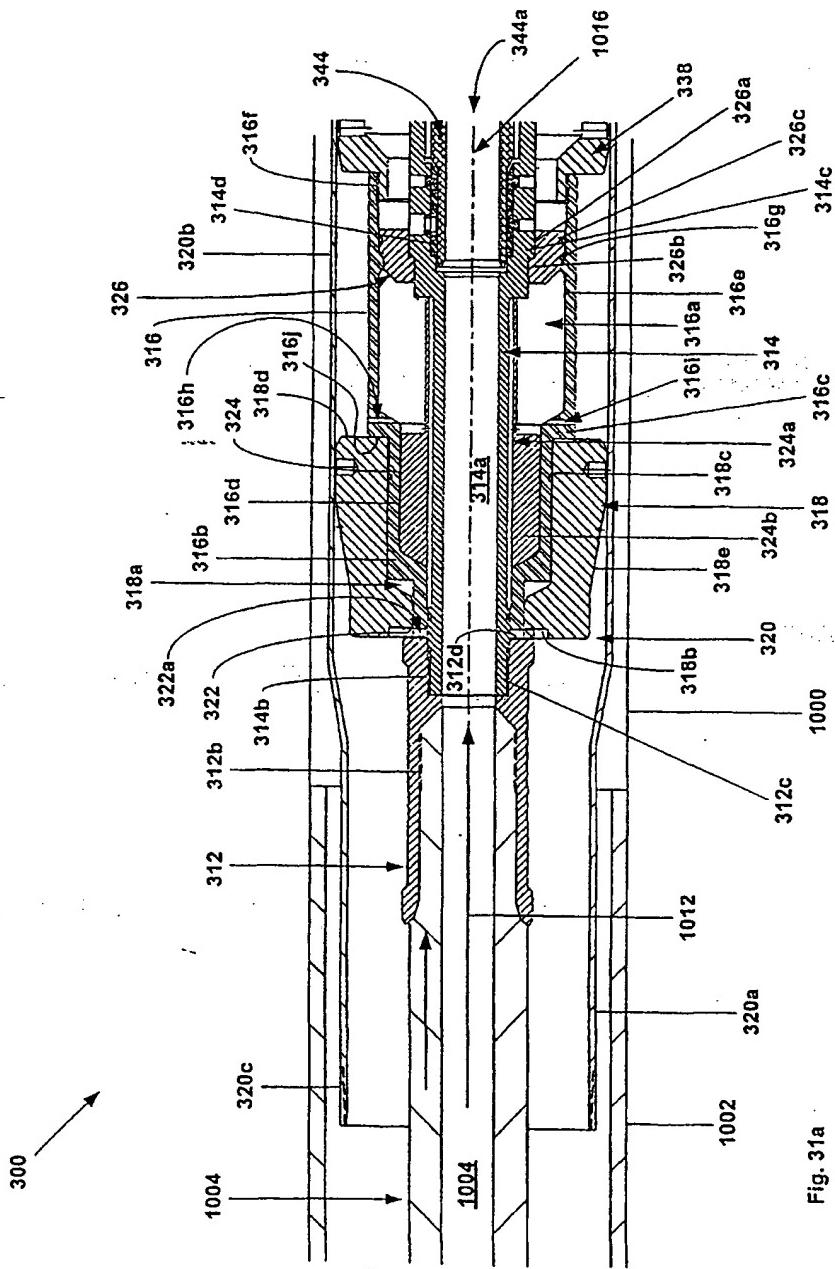


Fig. 31a

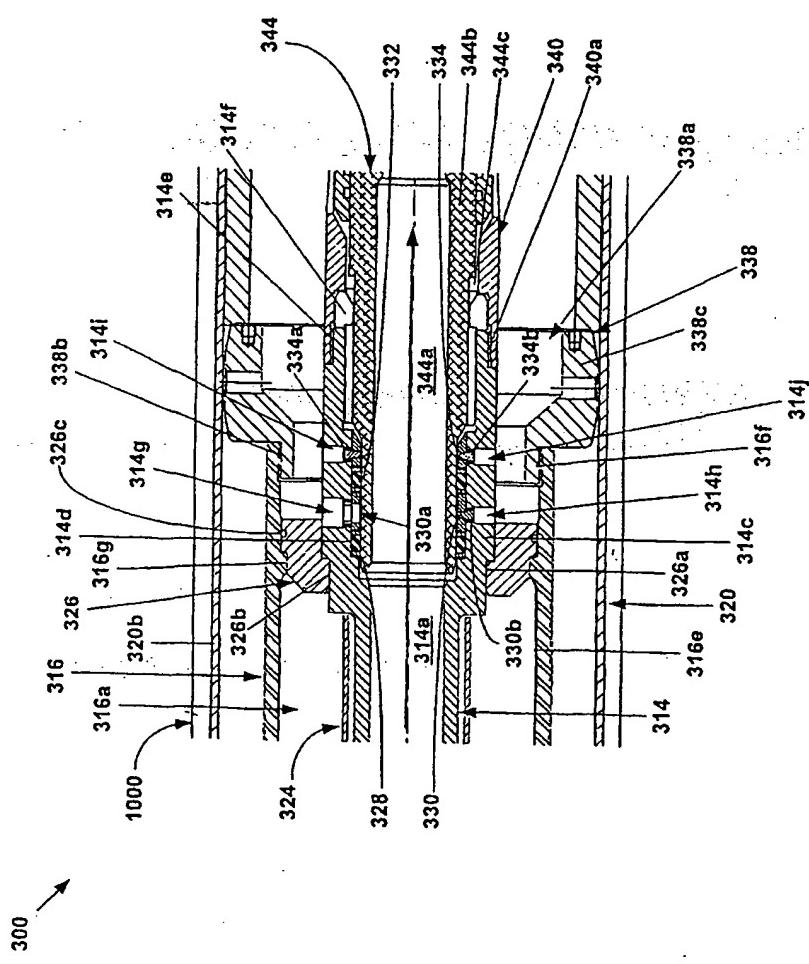


Fig. 31b

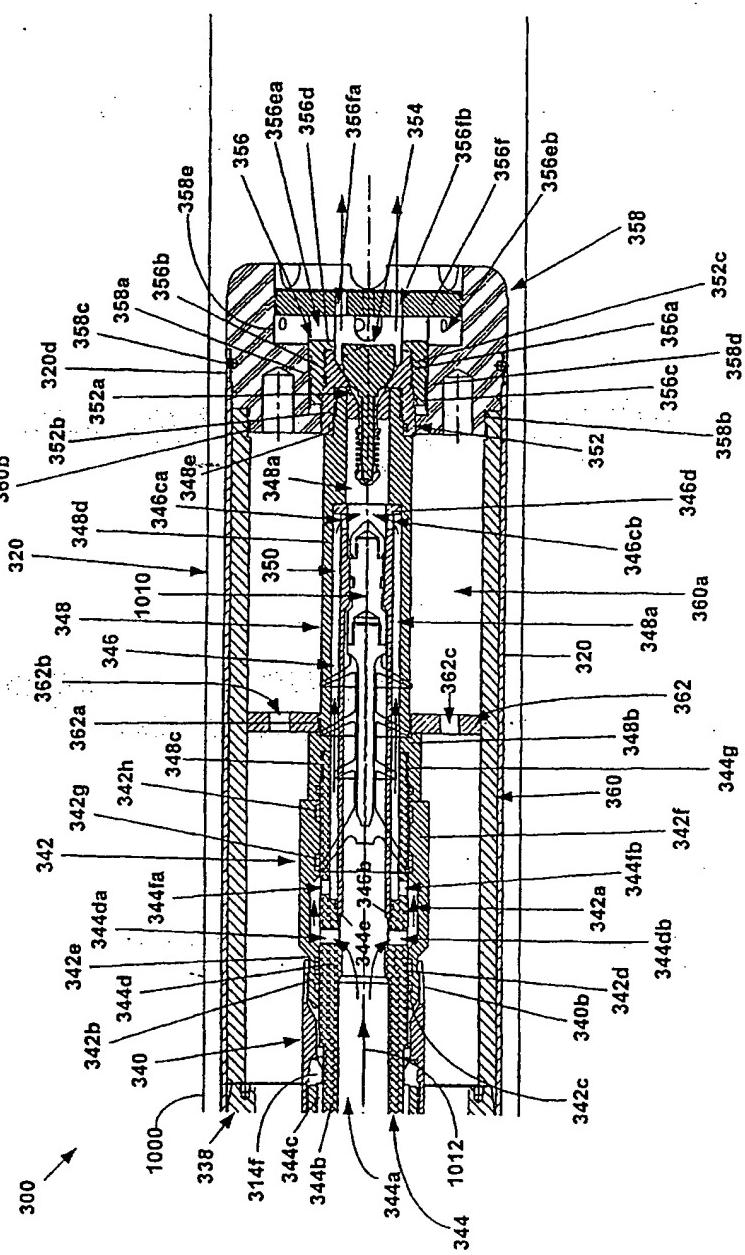


Fig. 31c

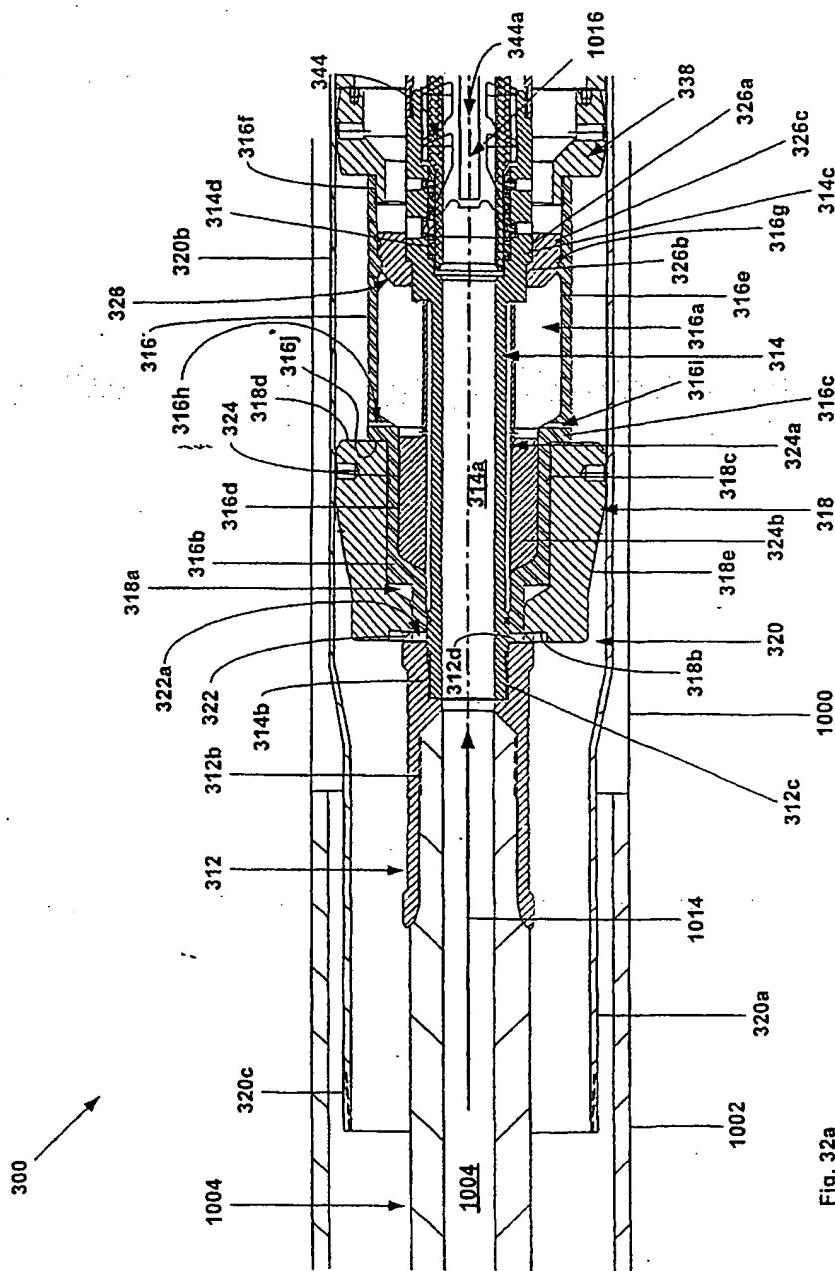


Fig. 32a

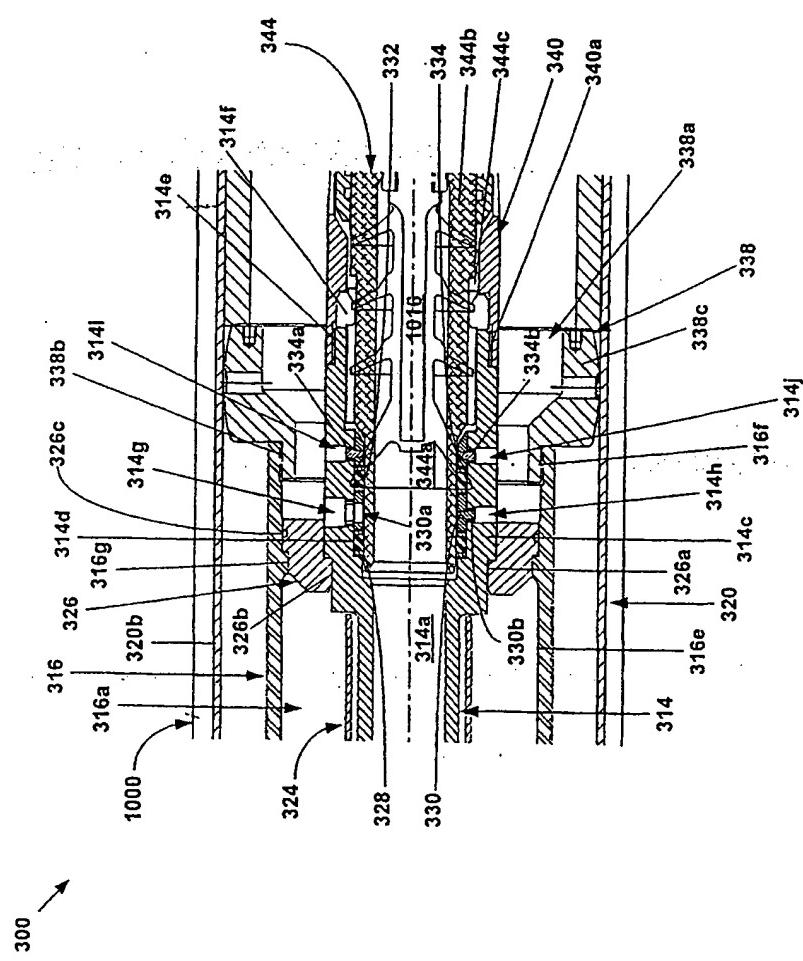


Fig. 32b

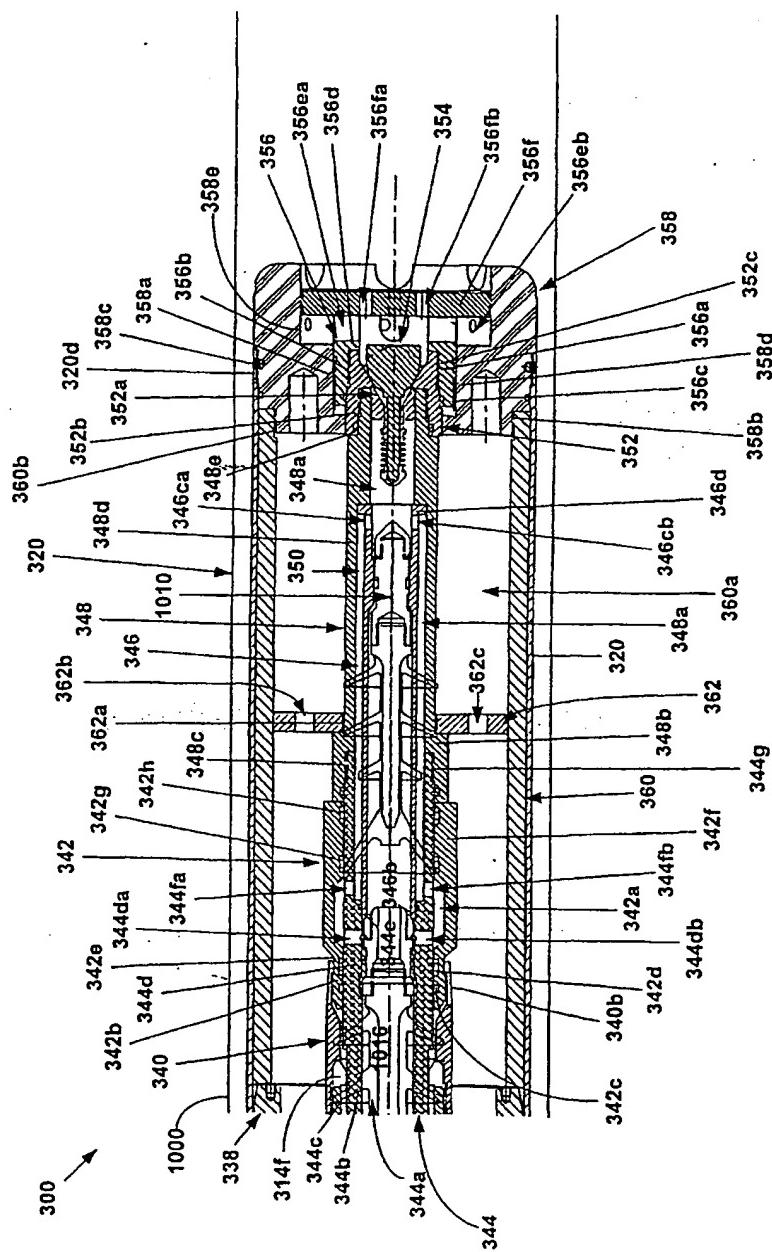


Fig. 32c

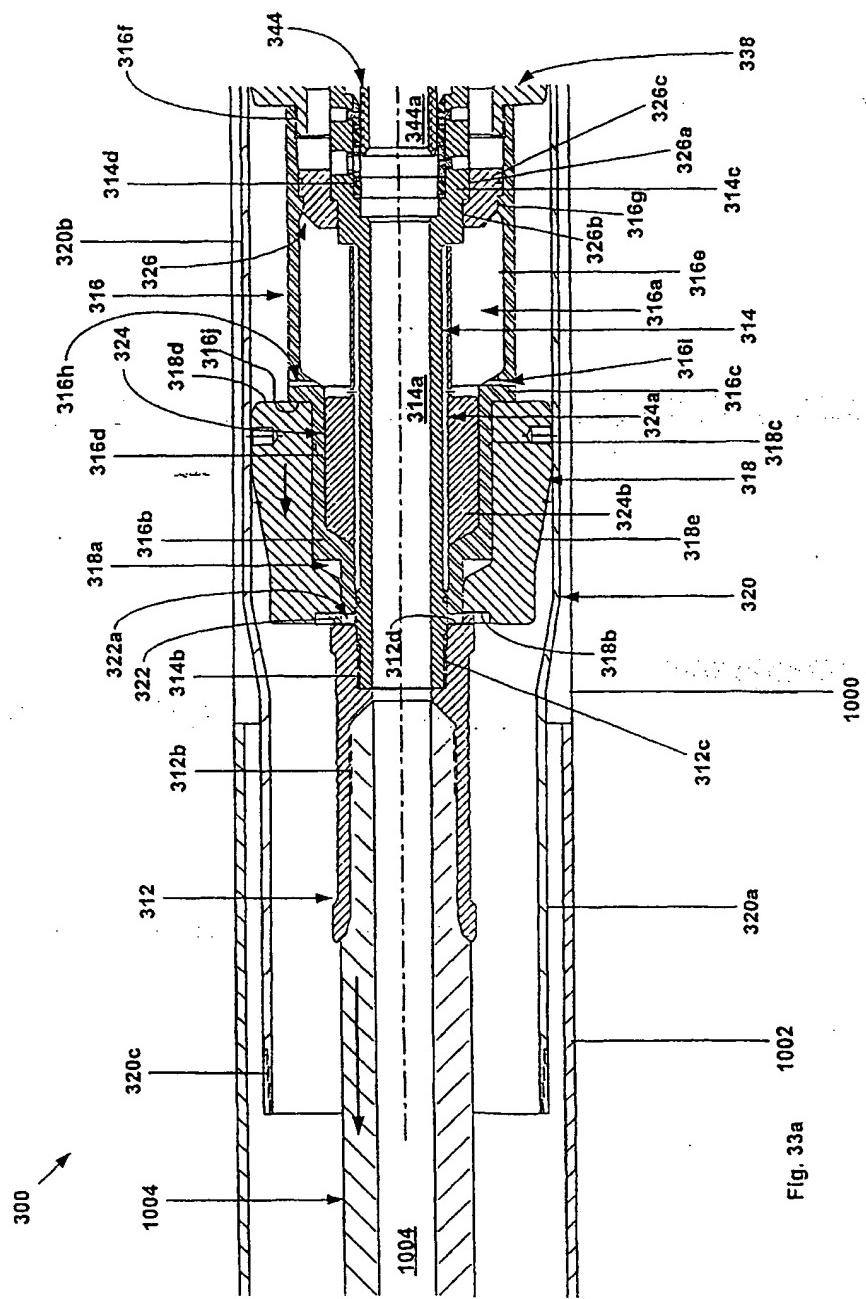
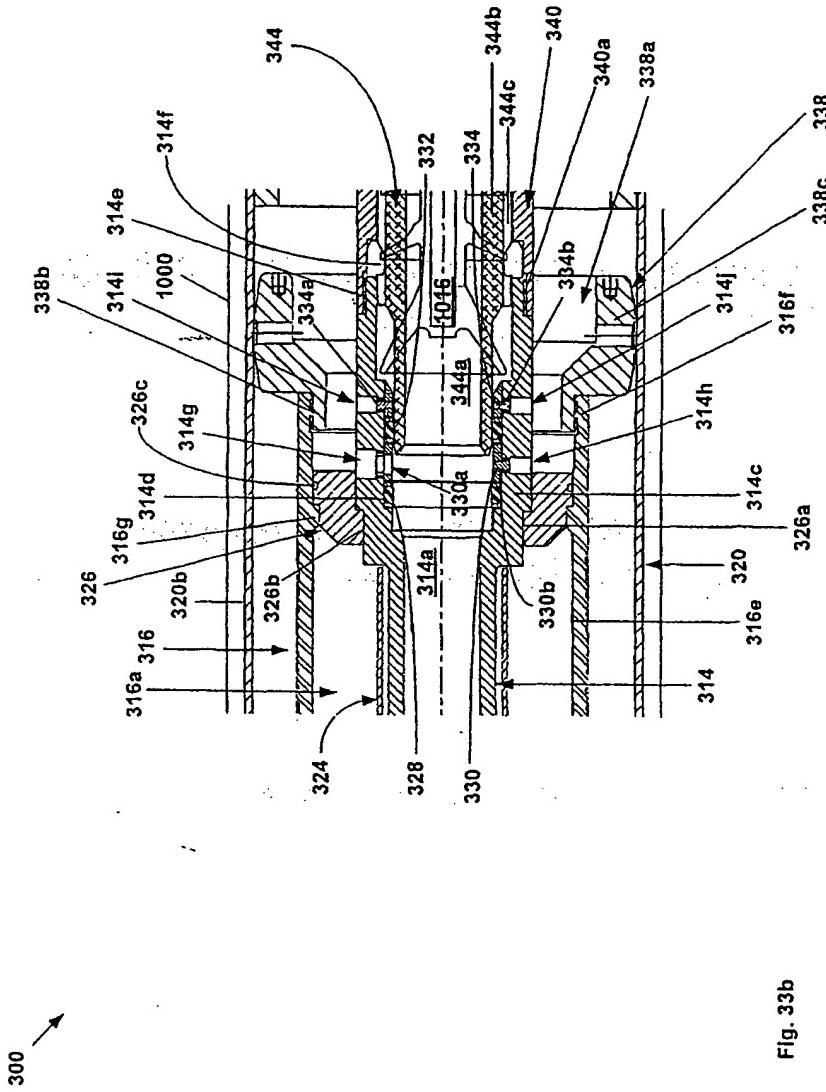


Fig. 33a 1002



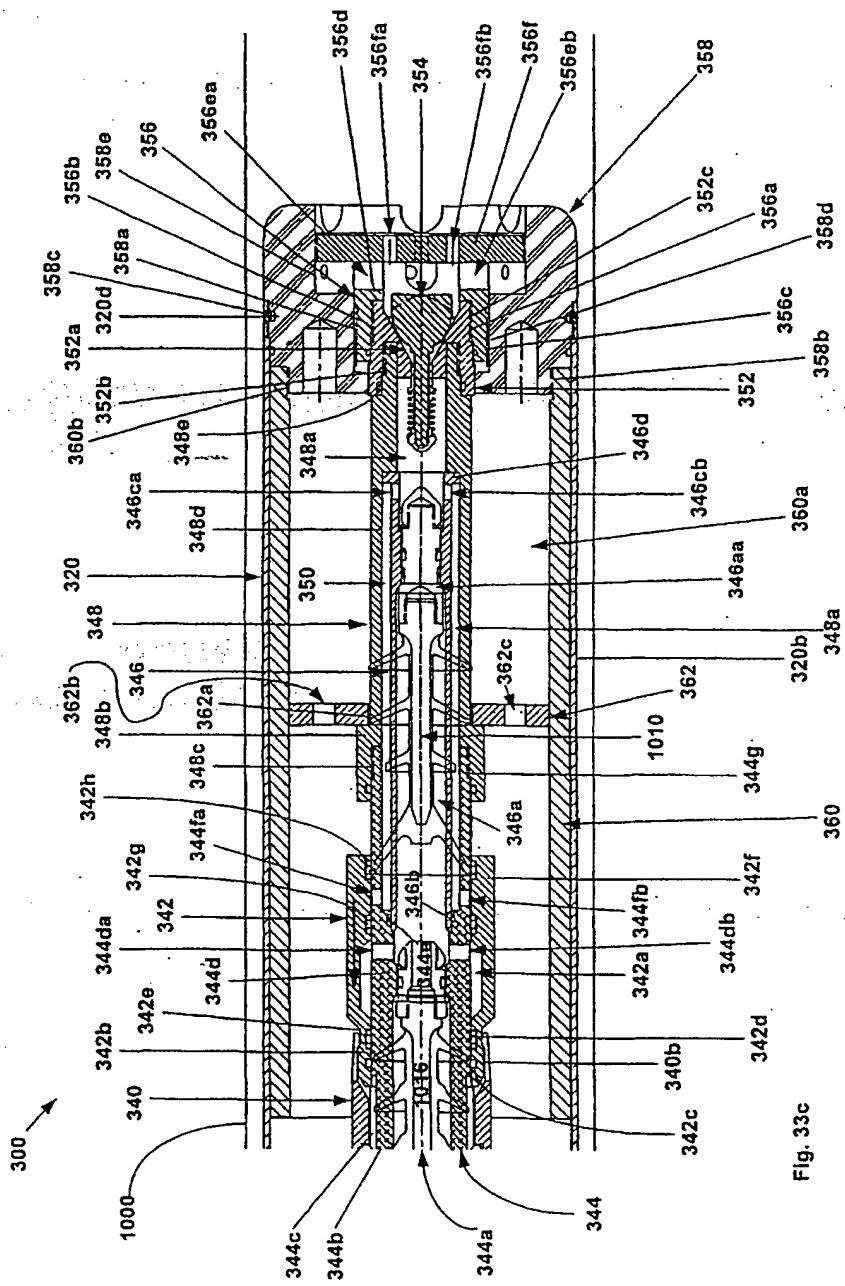


Fig. 33c

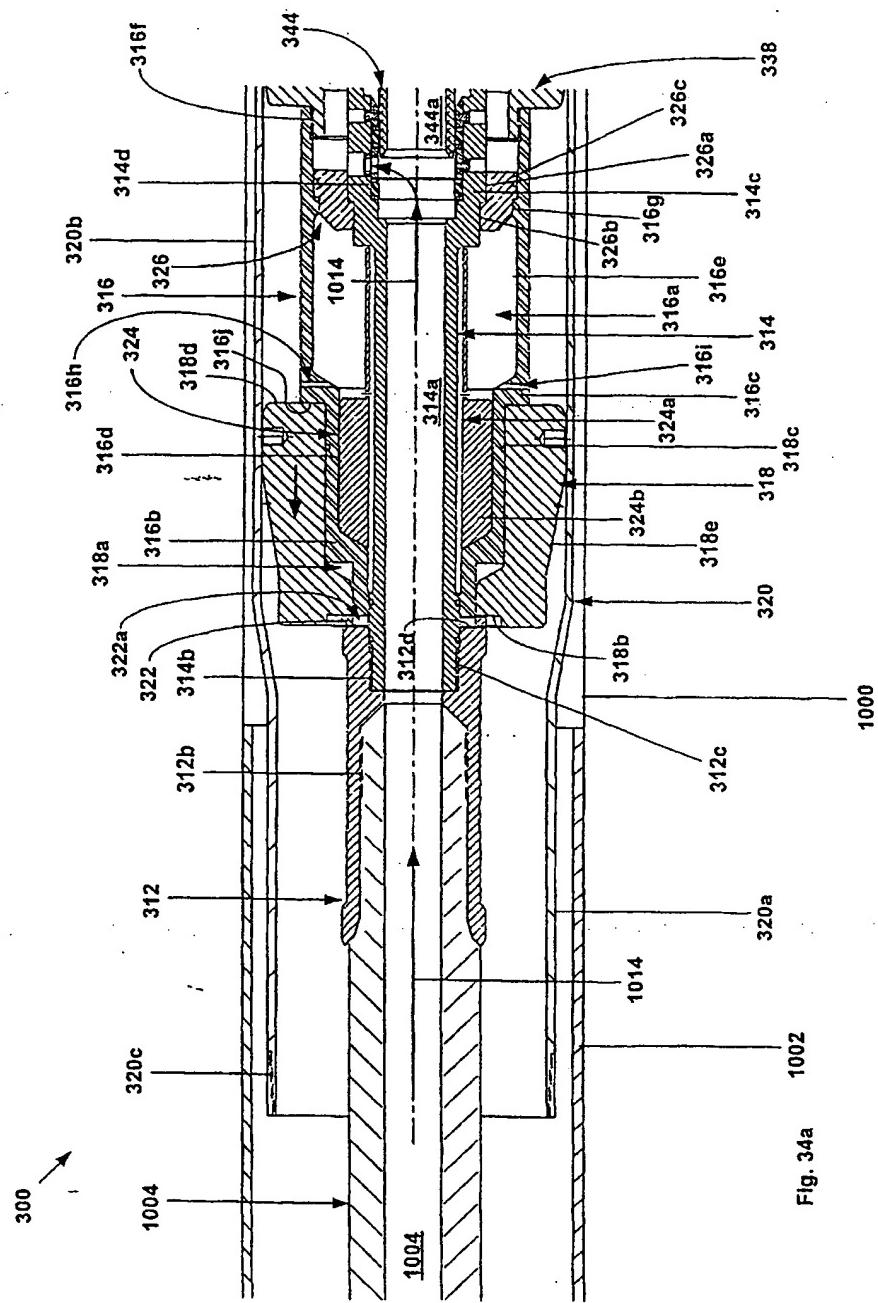
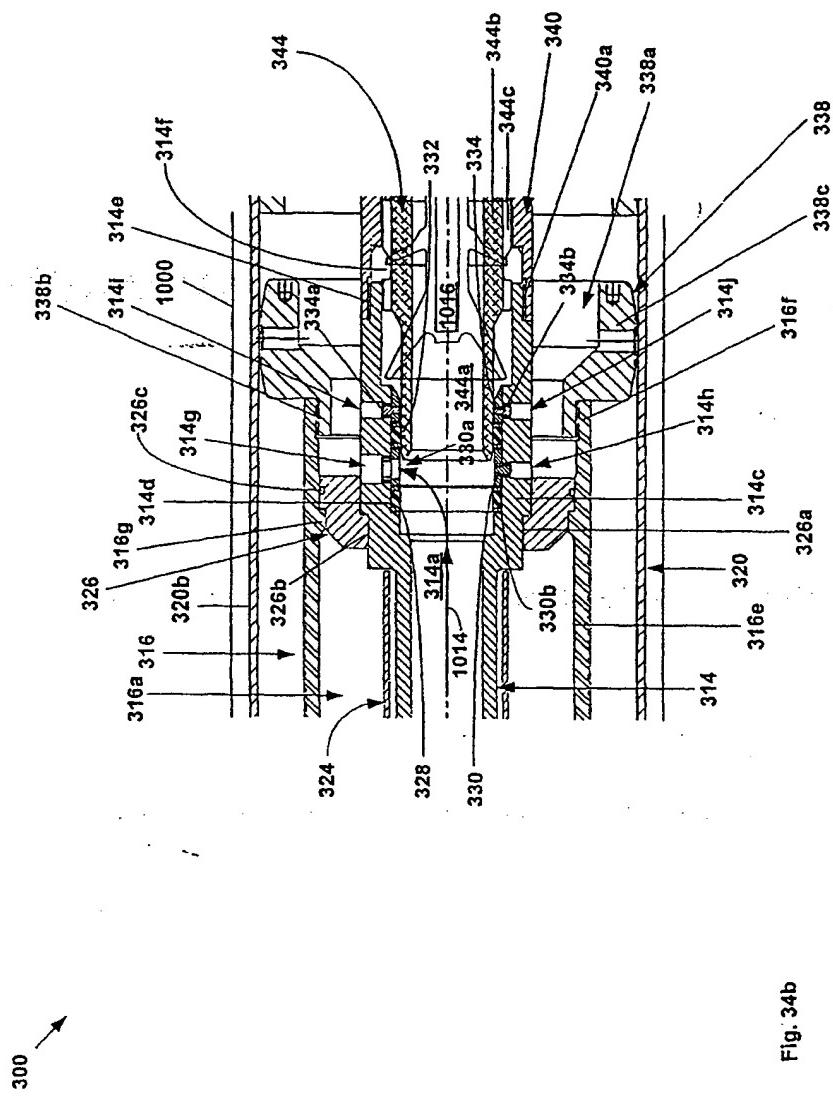
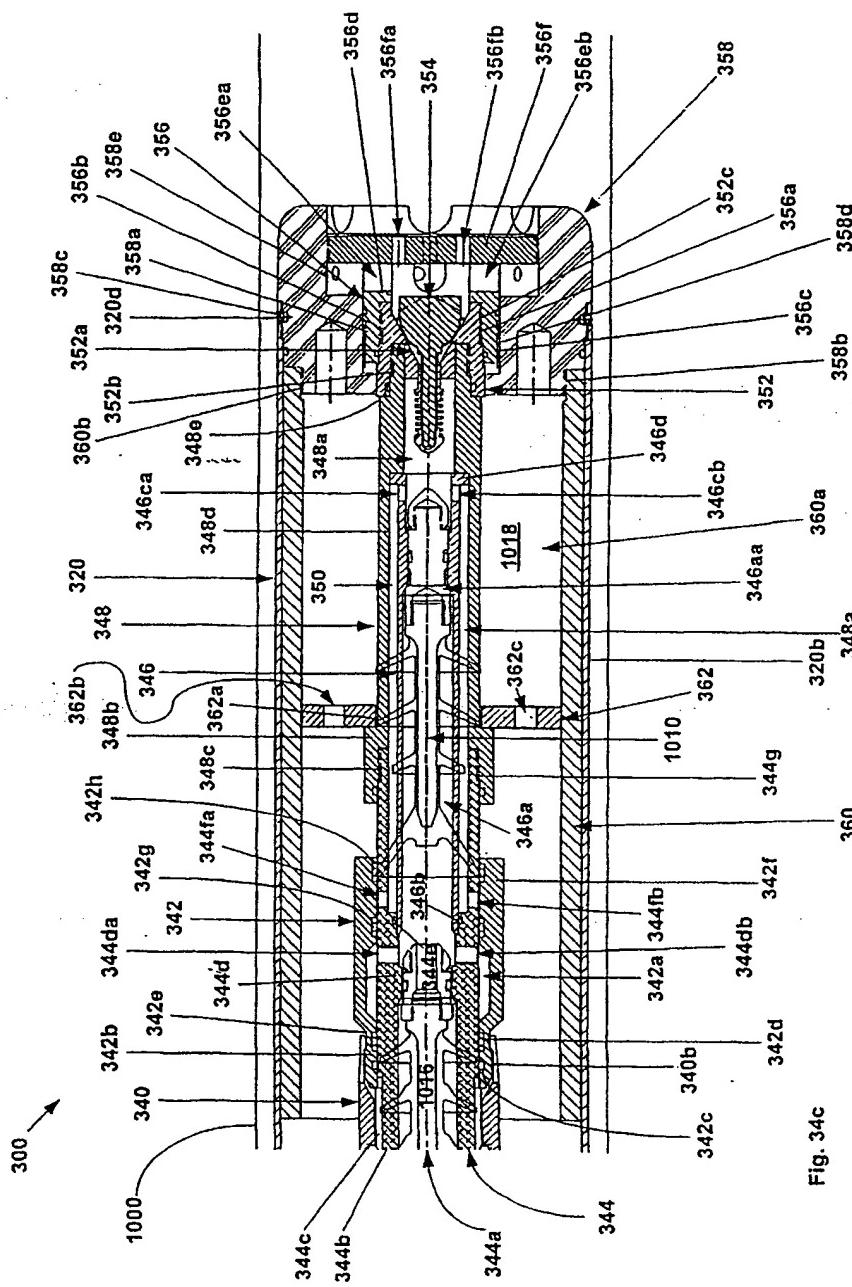


Fig. 34a





FORMING A WELLBORE CASING

Background of the Invention

This invention relates generally to forming wellbore casings.

Conventionally, when a wellbore is created, a number of casings are installed

- 5 in the borehole to prevent collapse of the borehole wall and to prevent undesired outflow of drilling fluid into the formation or inflow of fluid from the formation into the borehole. The borehole is drilled in intervals whereby a casing which is to be installed in a lower borehole interval is lowered through a previously installed casing of an upper borehole interval. As a consequence of this procedure the casing
- 10 of the lower interval is of smaller diameter than the casing of the upper interval.

Thus, the casings are in a nested arrangement with casing diameters decreasing in downward direction. Cement annuli are provided between the outer surfaces of the casings and the borehole wall to seal the casings from the borehole wall. As a consequence of this nested arrangement a relatively large borehole diameter is

- 15 required at the upper part of the wellbore. Such a large borehole diameter involves increased costs due to heavy casing handling equipment, large drill bits and increased volumes of drilling fluid and drill cuttings. Moreover, increased drilling rig time is involved due to required cement pumping, cement hardening, required equipment changes due to large variations in hole diameters drilled in the course of
- 20 the well, and the large volume of cuttings drilled and removed.

The present invention is directed to overcoming one or more of the limitations of the existing procedures for forming wellbores.

Summary of the Invention

- 25 According to the present invention there is provided an apparatus for forming a wellbore casing in a borehole in a subterranean formation, comprising:
 - means for radially expanding and plastically deforming an expandable tubular member; and
 - means for injecting a hardenable fluidic sealing material into an annulus
- 30 between the expandable tubular member and the borehole;

wherein the means for injecting a hardenable fluidic sealing material into an annulus between the expandable tubular member and the borehole, comprises a sliding sleeve valve.

- According to another aspect of the present invention there is provided an
5 apparatus for coupling an expandable tubular member to a preexisting structure,
comprising:

means for radially expanding and plastically deforming the expandable tubular
member within the preexisting structure; and

- means for injecting a hardenable fluidic sealing material into an annulus
10 between the expandable tubular member and the preexisting structure;
wherein the means for injecting a hardenable fluidic sealing material into an annulus
between the expandable tubular member and the preexisting structure, comprises a
sliding sleeve valve.

Brief Description of the Drawings

- 15 Figs. 1 and 1a-1c are cross sectional illustrations of a liner hanger assembly
including a sliding sleeve valve assembly.

Figs. 2a-2b is a flow chart illustration of a method for forming a wellbore
casing using the liner hanger assembly of Figs. 1 and 1a-1c.

- 20 Figs. 3a-3c are cross sectional illustrations of the placement of the liner
hanger assembly of Figs. 1 and 1a-1c into a wellbore.

Figs. 4a-4c are cross sectional illustrations of the injection of fluidic
materials into the liner hanger assembly of Figs. 3a-3c.

Figs. 5a-5c are cross sectional illustrations of the placement of a bottom plug
into the liner hanger assembly of Figs. 4a-4c.

- 25 Figs. 6a-6c are cross sectional illustrations of the downward displacement of
sliding sleeve of the liner hanger assembly of Figs. 5a-5c.

Figs. 7a-7c are cross sectional illustrations of the injection of a hardenable
fluidic sealing material into the liner hanger assembly of Figs. 6a-6c that bypasses
the plug.

Figs. 8a-8c are cross sectional illustrations of the placement of a top plug into the liner hanger assembly of Figs. 7a-7c.

Figs. 9a-9c are cross sectional illustrations of the upward displacement of sliding sleeve of the liner hanger assembly of Figs. 8a-8c.

5 Figs. 10a-10c are cross sectional illustrations of the injection of a pressurized fluidic material into the liner hanger assembly of Figs. 9a-9c in order to radially expand and plastically deform the expansion cone launcher.

Figs. 11a-11b is a flow chart illustration of a method for forming a wellbore casing using the liner hanger assembly of Figs. 1 and 1a-1c.

10 Figs. 12a-12c are cross sectional illustrations of the injection of a pressurized fluidic material into the liner hanger assembly of Figs. 5a-5c in order to at least partially radially expand and plastically deform the expansion cone launcher.

Figs. 13a-13c are cross sectional illustrations of the downward displacement of the sliding sleeve of the liner hanger assembly of Figs. 12a-12c.

15 Figs. 14a-14c are cross sectional illustrations of the injection of a hardenable fluidic sealing material through the liner hanger assembly of Figs. 13a-13c.

Figs. 15a-15c are cross sectional illustrations of the injection and placement of a top plug into the liner hanger assembly of Figs. 14a-14c.

20 Figs. 16a-16c are cross sectional illustrations of the upward displacement of the sliding sleeve of the liner hanger assembly of Figs. 15a-15c.

Figs. 17a-17c are cross sectional illustrations of the injection of a pressurized fluidic material into the liner hanger assembly of Figs. 16a-16c in order to complete the radial expansion of the expansion cone launcher.

25 Figs. 18, 18a, 18b, and 18c are cross sectional illustrations of a liner hanger assembly including a sliding sleeve valve assembly.

Figs. 19a-19b is a flow chart illustration of a method for forming a wellbore casing using the liner hanger assembly of Figs. 18 and 18a-18c.

Figs. 20a-20c are cross sectional illustrations of the placement of the liner hanger assembly of Figs. 18 and 18a-18c into a wellbore.

Figs. 21a-21c are cross sectional illustrations of the injection of a fluidic materials into the liner hanger assembly of Figs. 20a-20c.

Figs. 22a-22c are cross sectional illustrations of the placement of a bottom plug into the liner hanger assembly of Figs. 21a-21c.

5 Figs. 23a-23c are cross sectional illustrations of the downward displacement of sliding sleeve of the liner hanger assembly of Figs. 22a-22c.

Figs. 24a-24c are cross sectional illustrations of the injection of a hardenable fluidic sealing material into the liner hanger assembly of Figs. 23a-23c that bypasses the bottom plug.

10 Figs. 25a-25c are cross sectional illustrations of the placement of a top plug into the liner hanger assembly of Figs. 24a-24c.

Figs. 26a-26c are cross sectional illustrations of the upward displacement of sliding sleeve of the liner hanger assembly of Figs. 25a-25c.

15 Figs. 27a-27c are cross sectional illustrations of the injection of a pressurized fluidic material into the liner hanger assembly of Figs. 26a-26c in order to radially expand and plastically deform the expansion cone launcher.

Figs. 28a-28b is a flow chart illustration of a method for forming a wellbore casing using the liner hanger assembly of Figs. 18 and 18a-18c.

20 Figs. 29a-29c are cross sectional illustrations of the injection of a pressurized fluidic material into the liner hanger assembly of Figs. 22a-22c in order to at least partially radially expand and plastically deform the expansion cone launcher.

Figs. 30a-30c are cross sectional illustrations of the downward displacement of the sliding sleeve of the liner hanger assembly of Figs. 29a-29c.

25 Figs. 31a-31c are cross sectional illustrations of the injection of a hardenable fluidic sealing material through the liner hanger assembly of Figs. 30a-30c.

Figs. 32a-32c are cross sectional illustrations of the injection and placement of a top plug into the liner hanger assembly of Figs. 31a-31c.

Figs. 33a-33c are cross sectional illustrations of the upward displacement of the sliding sleeve of the liner hanger assembly of Figs. 32a-32c.

Figs. 34a-34c are cross sectional illustrations of the injection of a pressurized fluidic material into the liner hanger assembly of Figs. 33a-33c in order to complete the radial expansion of the expansion cone launcher.

5

Detailed Description

A liner hanger assembly having a sliding sleeve bypass valve is provided. The liner hanger assembly provides a method and apparatus for forming or repairing a wellbore casing, a pipeline or a structural support.

Referring initially to Figs. 1, 1a, 1b, and 1c, a liner hanger assembly 10 includes a first tubular support member 12 defining an internal passage 12a that includes a threaded counterbore 12b at one end, and a threaded counterbore 12c at another end. A second tubular support member 14 defining an internal passage 14a includes a first threaded portion 14b at a first end that is coupled to the threaded counterbore 12c of the first tubular support member 12, a stepped flange 14c, a counterbore 14d, a threaded portion 14e, and internal splines 14f at another end.

The stepped flange 14c of the second tubular support member 14 further defines radial passages 14g, 14h, 14i, and 14j. A third tubular support member 16 defining an internal passage 16a for receiving the second tubular support member 14 includes a first flange 16b, a second flange 16c, a first counterbore 16d, a second counterbore 16e having an internally threaded portion 16f, and an internal flange 16g. The second flange 16c further includes radial passages 16h and 16i.

An annular expansion cone 18 defining an internal passage 18a for receiving the second and third tubular support members, 14 and 16, includes a counterbore 18b at one end, and a counterbore 18c at another end for receiving the flange 16b of the second tubular support member 16. The annular expansion cone 18 further includes an end face 18d that mates with an end face 16j of the flange 16c of the second tubular support member 16, and an exterior surface 18e having a conical shape in order to facilitate the radial expansion of tubular members. A tubular expansion cone launcher 20 is movably coupled to the exterior surface 18e of the expansion cone 18 and includes a first portion 20a having a first wall thickness, a

second portion 20b having a second wall thickness, a threaded portion 20c at one end, and a threaded portion 20d at another end. The second portion 20b of the expansion cone launcher 20 mates with the conical outer surface 18e of the expansion cone 18. The second wall thickness is less than the first wall thickness in

- 5 order to optimize the radial expansion of the expansion cone launcher 20 by the relative axial displacement of the expansion cone 18. One or more expandable tubulars are coupled to the threaded connection 20c of the expansion cone launcher 20. In this manner, the assembly 10 may be used to radially expand and plastically deform, for example, thousands of feet of expandable tubulars.

- 10 An annular spacer 22 defining an internal passage 22a for receiving the second tubular support member 14 is received within the counterbore 18b of the expansion cone 18, and is positioned between an end face 12d of the first tubular support member 12 and an end face of the counterbore 18b of the expansion cone 18. A fourth tubular support member 24 defining an internal passage 24a for receiving the second tubular support member 14 includes a flange 24b that is received within the counterbore 16d of the third tubular support member 16. A fifth tubular support member 26 defining an internal passage 26a for receiving the second tubular support member 14 includes an internal flange 26b for mating with the flange 14c of the second tubular support member and a flange 26c for mating with 20 the internal flange 16g of the third tubular support member 16.

- An annular sealing member 28, an annular sealing and support member 30, an annular sealing member 32, and an annular sealing and support member 34 are received within the counterbore 14d of the second tubular support member 14. The annular sealing and support member 30 further includes a radial opening 30a for supporting a rupture disc 36 within the radial opening 14g of the second tubular support member 14 and a sealing member 30b for sealing the radial opening 14h of the second tubular support member. The annular sealing and support member 34 further includes sealing members 34a and 34b for sealing the radial openings 14i and 14j, respectively, of the second tubular support member 14. The rupture disc 36 opens when the operating pressure within the radial opening 30b is about 6,894.745

to 34,473.724 KPa (1000 to 5000 psi). In this manner, the rupture disc 36 provides a pressure sensitive valve for controlling the flow of fluidic materials through the radial opening 30a. Alternatively, the assembly 10 includes a plurality of radial passages 30a, each with corresponding rupture discs 36.

- 5 A sixth tubular support member 38 defining an internal passage 38a for receiving the second tubular support member 14 includes a threaded portion 38b at one end that is coupled to the threaded portion 16f of the third tubular support member 16 and a flange 38c at another end that is movably coupled to the interior of the expansion cone launcher 20. An annular collet 40 includes a threaded portion 10 40a that is coupled to the threaded portion 14e of the second tubular support member 14, and a resilient coupling 40b at another end.

An annular sliding sleeve 42 defining an internal passage 42a includes an internal flange 42b, having sealing members 42c and 42d, and an external groove 42e for releasably engaging the coupling 40b of the collet 40 at one end, and an internal flange 42f, having sealing members 42g and 42h, at another end. During operation the coupling 40b of the collet 40 may engage the external groove 42e of the sliding sleeve 42 and thereby displace the sliding sleeve in the longitudinal direction. Since the coupling 40b of the collet 40 is resilient, the collet 40 may be disengaged or reengaged with the sliding sleeve 42. An annular valve member 44 defining an internal passage 44a, having a first throat 44aa and a second throat 44ab, includes a flange 44b at one end, having external splines 44c for engaging the internal splines 14f of the second tubular support member 14, a first set of radial passages, 44da and 44db, a second set of radial passages, 44ea and 44eb, and a threaded portion 44f at another end. The sliding sleeve 42 and the valve member 44 define an annular bypass passage 46 that, depending upon the position of the sliding sleeve 42, permits fluidic materials to flow from the passage 44 through the first radial passages, 44da and 44db, the bypass passage 46, and the second radial passages, 44ea and 44eb, back into the passage 44. In this manner, fluidic materials may bypass the portion of the passage 44 between the first and second radial 20 passages, 44ea, 44eb, 44da, and 44db. Furthermore, the sliding sleeve 42 and the

valve member 44 together define a sliding sleeve valve for controllably permitting fluidic materials to bypass the intermediate portion of the passage 44a between the first and second passages, 44da, 44db, 44ea, and 44eb. During operation, the flange 44b limits movement of the sliding sleeve 42 in the longitudinal direction.

- 5 The collet 40 includes a set of couplings 40b such as, for example, fingers, that engage the external groove 42e of the sliding sleeve 42. During operation, the collet couplings 40b latch over and onto the external groove 42e of the sliding sleeve 42. A longitudinal force of at least about 4.448 to 57.827 kN (10,000 to 13,000 lbf) is required to pull the couplings 40b off of, and out of engagement with, the external
- 10 groove 42e of the sliding sleeve 42. The application of a longitudinal force less than about 4.448 to 57.827 kN (10,000 to 13,000 lbf) indicates that the collet couplings 40b are latched onto the external shoulder of the sliding sleeve 42, and that the sliding sleeve 42 is in the up or the down position relative to the valve member 44. The collet 40 includes a conventional internal shoulder that transfers the weight of
- 15 the first tubular support member 12 and expansion cone 18 onto the sliding sleeve 42. The collet 40 further includes a conventional set of internal lugs for engaging the splines 44c of the valve member 44.

- 20 An annular valve seat 48 defining a conical internal passage 48a for receiving a conventional float valve element 50 includes an annular recess 48b, having an internally threaded portion 48c for engaging the threaded portion 44f of the valve member 44, at one end, and an externally threaded portion 48d at another end. Alternatively, the float valve element 50 is omitted. An annular valve seat mounting element 52 defining an internal passage 52a for receiving the valve seat 48 and float valve 50 includes an internally threaded portion 52b for engaging the externally threaded portion 48d of the valve seat 48, an externally threaded portion 52c, an internal flange 52d, radial passages, 52ea and 52eb, and an end member 52f, having axial passages, 52fa and 52fb.
- 25 30 A shoe 54 defining an internal passage 54a for receiving the valve seat mounting element 52 includes a first annular recess 54b, having an externally threaded portion 54c, and a second annular recess 54d, having an externally threaded

portion 54e for engaging the threaded portion 20d of the expansion cone launcher 20, at one end, a first threaded counterbore 54f for engaging the threaded portion 52c of the mounting element, and a second counterbore 54g for mating with the end member 52f of the mounting element. The shoe 54 is fabricated from a

5 ceramic and/or a composite material in order to facilitate the subsequent removal of the shoe by drilling. A seventh tubular support member 56 defining an internal passage 56a for receiving the sliding sleeve 42 and the valve member 44 is positioned within the expansion cone launcher 20 that includes an internally threaded portion 56b at one end for engaging the externally threaded portion 54c of

10 the annular recess 54b of the shoe 54. During operation of the assembly, the end of the seventh tubular support member 56 limits the longitudinal movement of the expansion cone 18 in the direction of the shoe 54 by limiting the longitudinal movement of the sixth tubular support member 38. An annular centralizer 58 defining an internal passage 58a for movably supporting the sliding sleeve 42 is

15 positioned within the seventh tubular support member 56 that includes axial passages 58b and 58c. The centralizer 58 maintains the sliding sleeve 42 and valve member 44 is a central position within the assembly 10.

Referring to Figs. 2a-2b, during operation, the assembly 10 may be used to form or repair a wellbore casing by implementing a method 200 in which, as

20 illustrated in Figs. 3a-3c, the assembly 10 may initially be positioned within a wellbore 100 having a preexisting wellbore casing 102 by coupling a conventional tubular member 104 defining an internal passage 104a to the threaded portion 12b of the first tubular support member 12 in step 202. During placement of the assembly 10 within the wellbore 100, fluidic materials 106 within the wellbore 100 below the

25 assembly 10 are conveyed through the assembly 10 and into the passage 104a by the fluid passages 52fa, 52fb, 54a, 48a, 44a, and 14a. In this manner, surge pressures that can be created during placement of the assembly 10 within the wellbore 100 are minimized. The float valve element 50 is pre-set in an auto-fill configuration to permit the fluidic materials 106 to pass through the conical passage 48a of the valve

30 seat 48.

Referring to Figs. 4a-4c, in step 204, fluidic materials 108 may then be injected into and through the tubular member 104 and assembly 10 to thereby ensure that all of the fluid passages 104a, 14a, 44a, 48a, 54a, 52fa, and 52fb are functioning properly.

- 5 Referring to Figs. 5a-5c, in step 206, a bottom plug 110 may then be injected into the fluidic materials 108 and into the assembly 10 and then positioned in the throat passage 44ab of the valve member 44. In this manner, the region of the passage 44a upstream from the plug 110 may be fluidically isolated from the region of the passage 44a downstream from the plug 110. The proper placement of the plug
- 10 110 may be indicated by a corresponding increase in the operating pressure of the fluidic material 108.

- Referring to Figs. 6a-6c, in step 208, the sliding sleeve 42 may then be displaced relative to the valve member 44 by displacing the tubular member 104 by applying, for example, a downward force of approximately 5,000 lbf on the
- 15 assembly 10. In this manner, the tubular member 104, the first tubular support member 12, the second tubular support member 14, the third tubular support member 16, the expansion cone 18, the annular spacer 22, the fourth tubular support member 24, the fifth tubular support member 26, the sixth tubular support member 38, the collet 40, and the sliding sleeve 42 are displaced in the longitudinal direction
 - 20 relative to the expansion cone launcher 20 and the valve member 44. In this manner, fluidic materials within the passage 44a upstream of the plug 110 may bypass the plug by passing through the first passages, 44da and 44db, through the annular passage 46, and through the second passages, 44ea and 44eb, into the region of the passage 44a downstream from the plug. Furthermore, in this manner, the
 - 25 rupture disc 36 is fluidically isolated from the passages 14a and 44a.

- Referring to Figs. 7a-7c, in step 210, a hardenable fluidic sealing material 112 may then be injected into the assembly 10 and conveyed through the passages 104a, 14a, 44a, 44da, 44db, 46, 44ea, 44eb, 48a, 54a, 52fa, and 52fb into the wellbore 100. In this manner, a hardenable fluidic sealing material such as, for example, cement, may be injected into the annular region between the expansion

cone launcher 20 and the wellbore 100 in order to subsequently form an annular body of cement around the radially expanded expansion cone launcher 20.

Furthermore, in this manner, the radial passage 30a and the rupture disc 36 are not exposed to the hardenable fluidic sealing material 112.

- 5 Referring to Figs. 8a-8c, in step 212, upon the completion of the injection of the hardenable fluidic sealing material 112, a nonhardenable fluidic material 114 may be injected into the assembly 10, and a top plug 116 may then be injected into the assembly 10 along with the fluidic materials 114 and then positioned in the throat passage 44aa of the valve member 44. In this manner, the region of the
- 10 passage 44a upstream from the first passages, 44da and 44db, may be fluidically isolated from the first passages. The proper placement of the plug 116 may be indicated by a corresponding increase in the operating pressure of the fluidic material 114.

- Referring to Fig. 9a-9c, in step 214, the sliding sleeve 42 may then be
- 15 displaced relative to the valve member 44 by displacing the tubular member 104 by applying, for example, an upward force of approximately 57.827 kN (13,000 lbf) on the assembly 10. In this manner, the tubular member 104, the first tubular support member 12, the second tubular support member 14, the third tubular support member 16, the expansion cone 18, the annular spacer 22, the fourth tubular support member 24, the fifth tubular support member 26, the sixth tubular support member 38, the collet 40, and the sliding sleeve 42 are displaced in the longitudinal direction relative to the expansion cone launcher 20 and the valve member 44. In this manner, fluidic materials within the passage 44a upstream of the plug 110 may no longer bypass the plug by passing through the first passages, 44da and 44db, through
- 20 the annular passage 46, and through the second passages, 44ea and 44eb, into the region of the passage 44a downstream from the plug. Furthermore, in this manner, the rupture disc 36 is no longer fluidically isolated from the fluid passages 14a and 44a.

- Referring to Figs. 10a-10c, in step 216, the fluidic material 114 may be
- 30 injected into the assembly 10. The continued injection of the fluidic material 114

may increase the operating pressure within the passages 14a and 44a until the burst disc 36 is opened thereby permitting the pressurized fluidic material 114 to pass through the radial passage 30a and into an annular region 118 defined by the second tubular support member 14, the third tubular support member 16, the sixth tubular support member 38, the collet 40, the sliding sleeve 42, the shoe 54, and the seventh tubular support member 56. The pressurized fluidic material 114 within the annular region 118 directly applies a longitudinal force upon the fifth tubular support member 26 and the sixth tubular support member 38. The longitudinal force in turn is applied to the expansion cone 18. In this manner, the expansion cone 18 is displaced relative to the expansion cone launcher 20 thereby radially expanding and plastically deforming the expansion cone launcher.

Alternatively in the method 200, the injection and placement of the top plug 116 into the liner hanger assembly 10 in step 212 may be omitted.

Alternatively, in the method 200, in step 202, the assembly 10 is positioned at the bottom of the wellbore 100.

As illustrated in Figs. 11a-11b, during operation, the assembly 10 may be used to form or repair a wellbore casing by implementing a method 250 in which, as illustrated in Figs. 3a-3c, the assembly 10 may initially be positioned within a wellbore 100 having a preexisting wellbore casing 102 by coupling a conventional tubular member 104 defining an internal passage 104a to the threaded portion 12b of the first tubular support member 12 in step 252. During placement of the assembly 10 within the wellbore 100, fluidic materials 106 within the wellbore 100 below the assembly 10 are conveyed through the assembly 10 and into the passage 104a by the fluid passages 52fa, 52fb, 54a, 48a, 44a, and 14a. In this manner, surge pressures that can be created during placement of the assembly 10 within the wellbore 100 are minimized. The float valve element 50 is pre-set in an auto-fill configuration to permit the fluidic materials 106 to pass through the conical passage 48a of the valve seat 48.

Referring to Figs. 4a-4c, in step 254, fluidic materials 108 may then be injected into and through the tubular member 104 and assembly 10 to thereby ensure

that all of the fluid passages 104a, 14a, 44a, 48a, 54a, 52fa, and 52fb are functioning properly.

Referring to Figs. 5a-5c, in step 256, the bottom plug 110 may then be injected into the fluidic materials 108 and into the assembly 10 and then positioned 5 in the throat passage 44ab of the valve member 44. In this manner, the region of the passage 44a upstream from the plug 110 may be fluidically isolated from the region of the passage 44a downstream from the plug 110. The proper placement of the plug 110 may be indicated by a corresponding increase in the operating pressure of the fluidic material 108.

10 Referring to Figs. 12a-12c, in step 258, a fluidic material 114 may then be injected into the assembly to thereby increase the operating pressure within the passages 14a and 44a until the burst disc 36 is opened thereby permitting the pressurized fluidic material 114 to pass through the radial passage 30a and into an annular region 118 defined by the second tubular support member 14, the third 15 tubular support member 16, the sixth tubular support member 38, the collet 40, the sliding sleeve 42, the shoe 54, and the seventh tubular support member 56. The pressurized fluidic material 114 within the annular region 118 directly applies a longitudinal force upon the fifth tubular support member 26 and the sixth tubular support member 38. The longitudinal force in turn is applied to the expansion cone 20 18. In this manner, the expansion cone 18 is displaced relative to the expansion cone launcher 20 thereby disengaging the collet 40 and the sliding sleeve 42 and radially expanding and plastically deforming the expansion cone launcher. The radial expansion process in step 408 is continued to a location below the overlap between the expansion cone launcher 20 and the preexisting wellbore casing 102.

25 Referring to Figs. 13a-13c, in step 260, the sliding sleeve 42 may then be displaced relative to the valve member 44 by (1) displacing the expansion cone 18 in a downward direction using the tubular member 104 and (2) applying, using the tubular member 104 a downward force of, for example, approximately 2.224 kN (5,000 lbf) on the assembly 10. In this manner, the coupling 40b of the collet 40 30 reengages the external groove 42e of the sliding sleeve 42. Furthermore, in this

manner, the tubular member 104, the first tubular support member 12, the second tubular support member 14, the third tubular support member 16, the expansion cone 18, the annular spacer 22, the fourth tubular support member 24, the fifth tubular support member 26, the sixth tubular support member 38, the collet 40, and the

5 sliding sleeve 42 are displaced in the longitudinal direction relative to the expansion cone launcher 20 and the valve member 44. In this manner, fluidic materials within the passage 44a upstream of the plug 110 may bypass the plug by passing through the first passages, 44da and 44db, through the annular passage 46, and through the second passages, 44ea and 44eb, into the region of the passage 44a downstream

10 from the plug. Furthermore, in this manner, the fluid passage 30a is fluidically isolated from the passages 14a and 44a.

Referring to Figs. 14a-14c, in step 262, the hardenable fluidic sealing material 112 may then be injected into the assembly 10 and conveyed through the passages 104a, 14a, 44a, 44da, 44db, 46, 44ea, 44eb, 48a, 54a, 52fa, and 52fb into

15 the wellbore 100. In this manner, a hardenable fluidic sealing material such as, for example, cement, may be injected into the annular region between the expansion cone launcher 20 and the wellbore 100 in order to subsequently form an annular body of cement around the radially expanded expansion cone launcher 20.

Furthermore, in this manner, the radial passage 30a and the rupture disc 36 are not

20 exposed to the hardenable fluidic sealing material 112.

Referring to Figs. 15a-15c, in step 264, upon the completion of the injection of the hardenable fluidic sealing material 112, the nonhardenable fluidic material 114 may be injected into the assembly 10, and the top plug 116 may then be injected into the assembly 10 along with the fluidic materials 114 and then positioned in the

25 throat passage 44aa of the valve member 44. In this manner, the region of the passage 44a upstream from the first passages, 44da and 44db, may be fluidically isolated from the first passages. The proper placement of the plug 116 may be indicated by a corresponding increase in the operating pressure of the fluidic material 114.

Referring to Figs. 16a-16c, in step 266, the sliding sleeve 42 may then be displaced relative to the valve member 44 by displacing the tubular member 104 by applying, for example, an upward force of approximately 57.827 kN (13,000 lbf) on the assembly 10. In this manner, the tubular member 104, the first tubular support member 12, the second tubular support member 14, the third tubular support member 16, the expansion cone 18, the annular spacer 22, the fourth tubular support member 24, the fifth tubular support member 26, the sixth tubular support member 38, the collet 40, and the sliding sleeve 42 are displaced in the longitudinal direction relative to the expansion cone launcher 20 and the valve member 44. In this manner, fluidic materials within the passage 44a upstream of the plug 110 may no longer bypass the plug by passing through the first passages, 44da and 44db, through the annular passage 46, and through the second passages, 44ea and 44eb, into the region of the passage 44a downstream from the plug. Furthermore, in this manner, the passage 30a is no longer fluidically isolated from the fluid passages 14a and 44a.

Referring to Figs. 17a-17c, in step 268, the fluidic material 114 may be injected into the assembly 10. The continued injection of the fluidic material 114 may increase the operating pressure within the passages 14a, 30a, and 44a and the annular region 118. The pressurized fluidic material 114 within the annular region 118 directly applies a longitudinal force upon the fifth tubular support member 26 and the sixth tubular support member 38. The longitudinal force in turn is applied to the expansion cone 18. In this manner, the expansion cone 18 is displaced relative to the expansion cone launcher 20 thereby completing the radial expansion of the expansion cone launcher.

Alternatively, in the method 250, the injection and placement of the top plug 116 into the liner hanger assembly 10 in step 264 may be omitted.

Alternatively, in the method 250, in step 252, the assembly 10 is positioned at the bottom of the wellbore 100.

Alternatively, in the method 250: (1) in step 252, the assembly 10 is positioned proximate a position below a preexisting section of the wellbore casing 102, and (2) in step 258, the expansion cone launcher 20, and any expandable

tubulars coupled to the threaded portion 20c of the expansion cone launcher, are radially expanded and plastically deformed until the shoe 54 of the assembly 10 is proximate the bottom of the wellbore 100. In this manner, the radial expansion process using the assembly 10 provides a telescoping of the radially expanded

5 tubulars into the wellbore 100.

The assembly 10 may be operated to form a wellbore casing by including or excluding the float valve 50.

The float valve 50 may be operated in an auto-fill configuration in which tabs are positioned between the float valve 50 and the valve seat 48. In this manner,

10 fluidic materials within the wellbore 100 may flow into the assembly 10 from below thereby decreasing surge pressures during placement of the assembly 10 within the wellbore 100. Furthermore, pumping fluidic materials through the assembly 10 at rate of about 1.2 to 2m³/min (6 to 8 bbl/min) will displace the tabs from the valve seat 48 and thereby allow the float valve 50 to close.

15 Prior to the placement of any of the plugs, 110 and 116, into the assembly 10, fluidic materials can be circulated through the assembly 10 and into the wellbore 100.

Once the bottom plug 110 has been positioned into the assembly 10, fluidic materials can only be circulated through the assembly 10 and into the wellbore 100
20 if the sliding sleeve 42 is in the down position.

Once the sliding sleeve 42 is positioned in the down position, the passage 30a and rupture disc 36 are fluidically isolated from pressurized fluids within the assembly 10.

Once the top plug 116 has been positioned into the assembly 10, no fluidic
25 materials can be circulated through the assembly 10 and into the wellbore 100.

The assembly 10 may be operated to form or repair a wellbore casing, a pipeline, or a structural support.

Referring to Figs. 18, 18a, 18b, and 18c, a liner hanger assembly 300 includes a first tubular support member 312 defining an internal passage 312a that
30 includes a threaded counterbore 312b at one end, and a threaded counterbore 312c at

another end. A second tubular support member 314 defining an internal passage 314a includes a first threaded portion 314b at a first end that is coupled to the threaded counterbore 312c of the first tubular support member 312, a stepped flange 314c, a counterbore 314d, a threaded portion 314e, and internal splines 314f at 5 another end. The stepped flange 314c of the second tubular support member 314 further defines radial passages 314g, 314h, 314i, and 314j.

A third tubular support member 316 defining an internal passage 316a for receiving the second tubular support member 314 includes a first flange 316b, a second flange 316c, a first counterbore 316d, a second counterbore 316e having an 10 internally threaded portion 316f, and an internal flange 316g. The second flange 316c further includes radial passages 316h and 316i.

An annular expansion cone 318 defining an internal passage 318a for receiving the second and third tubular support members, 314 and 316, includes a counterbore 318b at one end, and a counterbore 318c at another end for receiving 15 the flange 316b of the second tubular support member 316. The annular expansion cone 318 further includes an end face 318d that mates with an end face 316j of the flange 316c of the second tubular support member 316, and an exterior surface 318e having a conical shape in order to facilitate the radial expansion of tubular members. A tubular expansion cone launcher 320 is movably coupled to the exterior surface 20 318e of the expansion cone 318 and includes a first portion 320a having a first wall thickness, a second portion 320b having a second wall thickness, a threaded portion 320c at one end, and a threaded portion 320d at another end. The second portion 320b of the expansion cone launcher 320 mates with the conical outer surface 318e of the expansion cone 318. The second wall thickness of the second portion 320b is 25 less than the first wall thickness of the first portion 320a in order to optimize the radial expansion of the expansion cone launcher 320 by the relative axial displacement of the expansion cone 318. One or more expandable tubulars are coupled to the threaded connection 320c of the expansion cone launcher 320. In this manner, the assembly 300 may be used to radially expand and plastically deform, 30 for example, thousands of feet of expandable tubulars.

An annular spacer 322 defining an internal passage 322a for receiving the second tubular support member 314 is received within the counterbore 318b of the expansion cone 318, and is positioned between an end face 312d of the first tubular support member 312 and an end face of the counterbore 318b of the expansion cone

- 5 318. A fourth tubular support member 324 defining an internal passage 324a for receiving the second tubular support member 314 includes a flange 324b that is received within the counterbore 316d of the third tubular support member 316. A fifth tubular support member 326 defining an internal passage 326a for receiving the second tubular support member 314 includes an internal flange 326b for mating with
10 the flange 314c of the second tubular support member and a flange 326c for mating with the internal flange 316g of the third tubular support member 316.

An annular sealing member 328, an annular sealing and support member 330, an annular sealing member 332, and an annular sealing and support member 334 are received within the counterbore 314d of the second tubular support member 314.

- 15 The annular sealing and support member 330 further includes a radial opening 330a for supporting a rupture disc 336 within the radial opening 314g of the second tubular support member 314 and a sealing member 330b for sealing the radial opening 314h of the second tubular support member. The annular sealing and support member 334 further includes sealing members 334a and 334b for sealing the
20 radial openings 314i and 314j, respectively, of the second tubular support member 314. The rupture disc 336 opens when the operating pressure within the radial opening 330b is about 6,894.745 to 34,473.724 KPa (1000 to 5000 psi). In this manner, the rupture disc 336 provides a pressure sensitive valve for controlling the flow of fluidic materials through the radial opening 330a. Alternatively, the
25 assembly 300 includes a plurality of radial passages 330a, each with corresponding rupture discs 336.

- 30 A sixth tubular support member 338 defining an internal passage 338a for receiving the second tubular support member 314 includes a threaded portion 338b at one end that is coupled to the threaded portion 316f of the third tubular support member 316 and a flange 338c at another end that is movably coupled to the interior

of the expansion cone launcher 320. An annular collet 340 includes a threaded portion 340a that is coupled to the threaded portion 314e of the second tubular support member 314, and a resilient coupling 340b at another end.

- An annular sliding sleeve 342 defining an internal passage 342a includes an internal flange 342b, having sealing members 342c and 342d, and an external groove 342e for releasably engaging the coupling 340b of the collet 340 at one end, and an internal flange 342f, having sealing members 342g and 342h, at another end. During operation, the coupling 340b of the collet 340 may engage the external groove 342e of the sliding sleeve 342 and thereby displace the sliding sleeve in the longitudinal direction. Since the coupling 340b of the collet 340 is resilient, the collet 340 may be disengaged or reengaged with the sliding sleeve 342. An annular valve member 344 defining an internal passage 344a, having a throat 344aa, includes a flange 344b at one end, having external splines 344c for engaging the internal splines 314f of the second tubular support member 314, an interior flange 10 344d having a first set of radial passages, 344da and 344db, and a counterbore 344e, a second set of radial passages, 344fa and 344fb, and a threaded portion 344g at another end.

- An annular valve member 346 defining an internal passage 346a, having a throat 346aa, includes an end portion 346b that is received in the counterbore 344e 20 of the annular valve member 344, a set of radial openings, 346ca and 346cb, and a flange 346d at another end. An annular valve member 348 defining an internal passage 348a for receiving the annular valve members 344 and 346 includes a flange 348b having a threaded counterbore 348c at one end for engaging the threaded portion 344g of the annular valve member, a counterbore 348d for mating with the flange 346d of the annular valve member, and a threaded annular recess 348e at 25 another end.

- The annular valve members 344, 346, and 348 define an annular passage 350 that fluidically couples the radial passages 344fa, 344fb, 346ca, and 346cb. Furthermore, depending upon the position of the sliding sleeve 342, the fluid 30 passages, 344da and 344db, may be fluidically coupled to the passages 344fa, 344fb,

346ca, 346cb, and 350. In this manner, fluidic materials may bypass the portion of the passage 346a between the passages 344da, 344db, 346ca, and 346cb.

Furthermore, the sliding sleeve 342 and the valve members 344, 346, and 348 together define a sliding sleeve valve for controllably permitting fluidic materials to

5 bypass the intermediate portion of the passage 346a between the passages, 344da, 344db, 346ca, and 346cb. During operation of the sliding sleeve valve, the flange 348b limits movement of the sliding sleeve 342 in the longitudinal direction.

The collet 340 includes a set of couplings 340b that engage the external groove 342e of the sliding sleeve 342. During operation, the collet couplings 340b

10 latch over and onto the external groove 342e of the sliding sleeve 342. A longitudinal force of at least about 4.448 to 57.827 kN (10,000 to 13,000 lbf) is required to pull the couplings 340b off of, and out of engagement with, the external groove 342e of the sliding sleeve 342. The application of a longitudinal force less than about 4.448 to 57.827 kN (10,000 to 13,000 lbf) indicates that the collet

15 couplings 340b are latched onto the external shoulder of the sliding sleeve 342, and that the sliding sleeve 342 is in the up or the down position relative to the valve member 344. The collet 340 includes a conventional internal shoulder that transfers the weight of the first tubular support member 312 and expansion cone 318 onto the sliding sleeve 342. The collet 340 further includes a conventional set of internal

20 lugs for engaging the splines 344c of the valve member 344.

An annular valve seat 352 defining a conical internal passage 352a for receiving a conventional float valve element 354 includes a threaded annular recess 352b for engaging the threaded portion 348e of the valve member 348, at one end, and an externally threaded portion 352c at another end. Alternatively, the float

25 valve element 354 is omitted. An annular valve seat mounting element 356 defining an internal passage 356a for receiving the valve seat 352 and float valve 354 includes an internally threaded portion 356b for engaging the externally threaded portion 352c of the valve seat 352, an externally threaded portion 356c, an internal flange 356d, radial passages, 356ea and 356eb, and an end member 356f, having

30 axial passages, 356fa and 356fb.

A shoe 358 defining an internal passage 358a for receiving the valve seat mounting element 356 includes a first threaded annular recess 358b, and a second threaded annular recess 358c for engaging the threaded portion 320d of the expansion cone launcher 320, at one end, a first threaded counterbore 358d for 5 engaging the threaded portion 356c of the valve seat mounting element, and a second counterbore 358e for mating with the end member 356f of the mounting element. The shoe 358 is fabricated from a ceramic and/or a composite material in order to facilitate the subsequent removal of the shoe by drilling.

A seventh tubular support member 360 defining an internal passage 360a for 10 receiving the sliding sleeve 342 and the valve members 344, 346, and 348 is positioned within the expansion cone launcher 320 that includes an internally threaded portion 360b at one end for engaging the externally threaded portion of the annular recess 358b of the shoe 358. During operation of the assembly, the end of the seventh tubular support member 360 limits the longitudinal movement of the 15 expansion cone 318 in the direction of the shoe 358 by limiting the longitudinal movement of the sixth tubular support member 338. An annular centralizer 362 defining an internal passage 362 for supporting the valve member 348 is positioned within the seventh tubular support member 360 that includes axial passages 362b and 362c.

20 Referring to Figs. 19a-19b, during operation, the assembly 300 may be used to form or repair a wellbore casing by implementing a method 400 in which, as illustrated in Figs. 20a-20c, the assembly 300 may initially be positioned within a wellbore 1000 having a preexisting wellbore casing 1002 by coupling a conventional tubular member 1004 defining an internal passage 1004a to the 25 threaded portion 312b of the first tubular support member 312 in step 402. During placement of the assembly 300 within the wellbore 1000, fluidic materials 1006 within the wellbore 1000 below the assembly 300 are conveyed through the assembly 300 and into the passage 1004a by the fluid passages 356fa, 356fb, 352a, 348a, 346a, 344a, and 314a. In this manner, surge pressures that can be created 30 during placement of the assembly 300 within the wellbore 1000 are minimized. The

float valve element 354 is pre-set in an auto-fill configuration to permit the fluidic materials 1006 to pass through the conical passage 352a of the valve seat 352.

Referring to Figs. 21a-21c, in step 404, fluidic materials 1008 may then be injected into and through the tubular member 1004 and assembly 300 to thereby

- 5 ensure that all of the fluid passages 1004a, 314a, 344a, 346a, 348a, 352a, 356fa, and 356fb are functioning properly.

Referring to Figs. 22a-22c, in step 406, a bottom plug 1010 may then be injected into the fluidic materials 1008 and into the assembly 300 and then positioned in the throat passage 346aa of the valve member 346. In this manner, the 10 region of the passage 346a upstream from the plug 1010 may be fluidically isolated from the region of the passage 346a downstream from the plug 1010. The proper placement of the plug 1010 may be indicated by a corresponding increase in the operating pressure of the fluidic material 1008.

- Referring to Figs. 23a-23c, in step 408, the sliding sleeve 342 may then be 15 displaced relative to the valve member 344 by displacing the tubular member 1004 by applying, for example, a downward force of approximately 2.224 kN (5,000 lbf) on the assembly 300. In this manner, the tubular member 1004, the first tubular support member 312, the second tubular support member 314, the third tubular support member 316, the expansion cone 318, the annular spacer 322, the fourth 20 tubular support member 324, the fifth tubular support member 326, the sixth tubular support member 338, the collet 340, and the sliding sleeve 342 are displaced in the longitudinal direction relative to the expansion cone launcher 320 and the valve member 344. In this manner, fluidic materials within the passage 344a upstream of the plug 1010 may bypass the plug by passing through the first passages, 344da and 25 344db, through the annular passage 342a, through the second passages, 344fa and 344fb, through the annular passage 350, through the passages, 346ca and 346cb, into the region of the passage 348a downstream from the plug. Furthermore, in this manner, the rupture disc 336 is fluidically isolated from the passages 314a and 344a.

- Referring to Figs. 24a-24c, in step 410, a hardenable fluidic sealing material 30 1012 may then be injected into the assembly 300 and conveyed through the passages

1004a, 314a, 344a, 344da, 344db, 342a, 344fa, 344fb, 350, 346ca, 346cb, 348a,
352a, 356fa, and 356fb into the wellbore 1000. In this manner, a hardenable fluidic
sealing material such as, for example, cement, may be injected into the annular
region between the expansion cone launcher 320 and the wellbore 1000 in order to
5 subsequently form an annular body of cement around the radially expanded
expansion cone launcher 320. Furthermore, in this manner, the radial passage 330a
and the rupture disc 336 are not exposed to the hardenable fluidic sealing material
1012.

Referring to Figs. 25a-25c, in step 412, upon the completion of the injection
10 of the hardenable fluidic sealing material 1012, a nonhardenable fluidic material
1014 may be injected into the assembly 300, and a top plug 1016 may then be
injected into the assembly 300 along with the fluidic materials 1014 and then
positioned in the throat passage 344aa of the valve member 344. In this manner, the
region of the passage 344a upstream from the top plug 1016 may be fluidically
15 isolated from region downstream from the top plug. The proper placement of the
plug 1016 may be indicated by a corresponding increase in the operating pressure of
the fluidic material 1014.

Referring to Fig. 26a-26c, in step 414, the sliding sleeve 42 may then be
displaced relative to the valve member 344 by displacing the tubular member 1004
20 by applying, for example, an upward force of approximately 57.827 kN (13,000 lbf)
on the assembly 300. In this manner, the tubular member 1004, the first tubular
support member 312, the second tubular support member 314, the third tubular
support member 316, the expansion cone 318, the annular spacer 322, the fourth
tubular support member 324, the fifth tubular support member 326, the sixth tubular
25 support member 338, the collet 340, and the sliding sleeve 342 are displaced in the
longitudinal direction relative to the expansion cone launcher 320 and the valve
member 344. In this manner, fluidic materials within the passage 344a upstream of
the bottom plug 1010 may no longer bypass the bottom plug by passing through the
first passages, 344da and 344db, through the annular passage 342a, through the
30 second passages, 344fa and 344fb, through the annular passage 350, and through the

passages, 346ca and 346cb, into region of the passage 348a downstream from the bottom plug. Furthermore, in this manner, the rupture disc 336 is no longer fluidically isolated from the fluid passages 314a and 344a.

Referring to Figs. 27a-27c, in step 416, the fluidic material 1014 may be

- 5 injected into the assembly 300. The continued injection of the fluidic material 1014 may increase the operating pressure within the passages 314a and 344a until the burst disc 336 is opened thereby permitting the pressurized fluidic material 1014 to pass through the radial passage 330a and into an annular region 1018 defined by the second tubular support member 314, the third tubular support member 316, the sixth
10 tubular support member 338, the collet 340, the sliding sleeve 342, the valve members, 344 and 348, the shoe 358, and the seventh tubular support member 360. The pressurized fluidic material 1014 within the annular region 1018 directly applies a longitudinal force upon the fifth tubular support member 326 and the sixth tubular support member 338. The longitudinal force in turn is applied to the expansion cone
15 318. In this manner, the expansion cone 318 is displaced relative to the expansion cone launcher 320 thereby radially expanding and plastically deforming the expansion cone launcher.

Alternatively, in the method 400, the injection and placement of the top plug 1016 into the liner hanger assembly 300 in step 412 may omitted.

- 20 Alternatively, in the method 400, in step 402, the assembly 300 is positioned at the bottom of the wellbore 1000.

As illustrated in Figs. 28a-28b, during operation, the assembly 300 may be used to form or repair a wellbore casing by implementing a method 450 in which, as illustrated in Figs. 20a-20c, the assembly 300 may initially be positioned within a
25 wellbore 1000 having a preexisting wellbore casing 1002 by coupling a conventional tubular member 1004 defining an internal passage 1004a to the threaded portion 312b of the first tubular support member 312 in step 452. During placement of the assembly 300 within the wellbore 1000, fluidic materials 1006 within the wellbore 1000 below the assembly 300 are conveyed through the
30 assembly 300 and into the passage 1004a by the fluid passages 356fa, 356fb, 352a,

348a, 346a, 344a, and 314a. In this manner, surge pressures that can be created during placement of the assembly 300 within the wellbore 1000 are minimized. The float valve element 354 is pre-set in an auto-fill configuration to permit the fluidic materials 1006 to pass through the conical passage 352a of the valve seat 352.

- 5 Referring to Figs. 21a-21c, in step 454, in step 454, fluidic materials 1008 may then be injected into and through the tubular member 1004 and assembly 300 to thereby ensure that all of the fluid passages 1004a, 314a, 344a, 346a, 348a, 352a, 356fa, and 356fb are functioning properly.

- Referring to Figs. 22a-22c, in step 456, the bottom plug 1010 may then be
10 injected into the fluidic materials 1008 and into the assembly 300 and then positioned in the throat passage 346aa of the valve member 346. In this manner, the region of the passage 346a upstream from the plug 1010 may be fluidically isolated from the region of the passage 346a downstream from the plug 1010. The proper placement of the plug 1010 may be indicated by a corresponding increase in the
15 operating pressure of the fluidic material 1008.

- Referring to Figs. 29a-29c, in step 458, the fluidic material 1014 may then be
injected into the assembly 300 to thereby increase the operating pressure within the
passages 314a and 344a until the burst disc 336 is opened thereby permitting the
pressurized fluidic material 1014 to pass through the radial passage 330a and into an
20 annular region 1018 defined by the second tubular support member 314, the third tubular support member 316, the sixth tubular support member 338, the collet 340, the sliding sleeve 342, the valve members, 344 and 348, the shoe 358, and the seventh tubular support member 360. The pressurized fluidic material 1014 within the annular region 1018 directly applies a longitudinal force upon the fifth
25 tubular support member 326 and the sixth tubular support member 338. The longitudinal force in turn is applied to the expansion cone 318. In this manner, the expansion cone 318 is displaced relative to the expansion cone launcher 320 thereby disengaging the collet 340 and the sliding sleeve 342 and radially expanding and plastically deforming the expansion cone launcher. The radial expansion process in

step 458 is continued to a location below the overlap between the expansion cone launcher 320 and the preexisting wellbore casing 1002.

Referring to Figs. 30a-30c, in step 460, the sliding sleeve 342 may then be displaced relative to the valve member 344 by (1) displacing the expansion cone 318

- 5 in a downward direction using the tubular member 1004 and (2) applying, using the tubular member 1004 a downward force of, for example, approximately 2.224 kN (5,000 lbf) on the assembly 300. In this manner, the coupling 340b of the collet 340 reengages the external groove 342e of the sliding sleeve 342. Furthermore, in this manner, the tubular member 1004, the first tubular support member 312, the second tubular support member 314, the third tubular support member 316, the expansion cone 318, the annular spacer 322, the fourth tubular support member 324, the fifth tubular support member 326, the sixth tubular support member 338, the collet 340, and the sliding sleeve 342 are displaced in the longitudinal direction relative to the expansion cone launcher 320 and the valve member 344. In this manner, fluidic
- 10 materials within the passage 344a upstream of the bottom plug 1010 may bypass the plug by passing through the passages, 344da and 344db, the annular passage 342a, the passages, 344fa and 344fb, the annular passage 350, and the passages, 346ca and 346cb, into the passage 348a downstream from the plug. Furthermore, in this manner, the fluid passage 330a is fluidically isolated from the passages 314a and 344a.
- 15
- 20

Referring to Figs. 31a-31c, in step 462, the hardenable fluidic sealing material 1012 may then be injected into the assembly 300 and conveyed through the passages 1004a, 314a, 344a, 344da, 344db, 342, 344fa, 344fb, 350, 346ca, 346cb, 348a, 352b, 356fa, and 356fb into the wellbore 1000. In this manner, a hardenable

- 25 fluidic sealing material such as, for example, cement, may be injected into the annular region between the expansion cone launcher 320 and the wellbore 1000 in order to subsequently form an annular body of cement around the radially expanded expansion cone launcher 320. Furthermore, in this manner, the radial passage 330a and the rupture disc 336 are not exposed to the hardenable fluidic sealing material
- 30 1012.

- Referring to Figs. 32a-32c, in step 464, upon the completion of the injection of the hardenable fluidic sealing material 1012, the nonhardenable fluidic material 1014 may be injected into the assembly 300, and the top plug 1016 may then be injected into the assembly 300 along with the fluidic materials 1014 and then
- 5 positioned in the throat passage 344aa of the valve member 344. In this manner, the region of the passage 344a upstream from the top plug 1016 may be fluidically isolated from the region within the passage downstream from the top plug. The proper placement of the plug 1016 may be indicated by a corresponding increase in the operating pressure of the fluidic material 1014.
- 10 Referring to Figs. 33a-33c, in step 466, the sliding sleeve 342 may then be displaced relative to the valve member 344 by displacing the tubular member 1004 by applying, for example, an upward force of approximately 57.827 kN (13,000 lbf) on the assembly 300. In this manner, the tubular member 1004, the first tubular support member 312, the second tubular support member 314, the third tubular support member 316, the expansion cone 318, the annular spacer 322, the fourth tubular support member 324, the fifth tubular support member 326, the sixth tubular support member 338, the collet 340, and the sliding sleeve 342 are displaced in the longitudinal direction relative to the expansion cone launcher 320 and the valve member 344. In this manner, fluidic materials within the passage 344a upstream of the bottom plug 110 may no longer bypass the plug by passing through the passages, 344da and 344db, the annular passage 342a, the passages, 344fa and 344fb, the annular passage 350, and the passages, 346ca and 346cb, into the passage 348a downstream from the plug. Furthermore, in this manner, the passage 330a is no longer fluidically isolated from the fluid passages 314a and 344a.
- 15
- 20
- 25 Referring to Figs. 34a-34c, in step 468, the fluidic material 1014 may be injected into the assembly 300. The continued injection of the fluidic material 1014 may increase the operating pressure within the passages 314a, 330a, and 344a and the annular region 1018. The pressurized fluidic material 1014 within the annular region 1018 directly applies a longitudinal force upon the fifth tubular support member 326 and the sixth tubular support member 338. The longitudinal force in
- 30

turn is applied to the expansion cone 318. In this manner, the expansion cone 318 is displaced relative to the expansion cone launcher 320 thereby completing the radial expansion of the expansion cone launcher.

Alternatively, in the method 450, the injection and placement of the top plug 5 1016 into the liner hanger assembly 300 in step 464 may omitted.

Alternatively, in the method 450, in step 452, the assembly 300 is positioned at the bottom of the wellbore 1000.

Alternatively, in the method 450: (1) in step 452, the assembly 300 is positioned proximate a position below a preexisting section of the wellbore casing 10 1002, and (2) in step 458, the expansion cone launcher 320, and any expandable tubulars coupled to the threaded portion 320c of the expansion cone launcher, are radially expanded and plastically deformed until the shoe 358 of the assembly 300 is proximate the bottom of the wellbore 1000. In this manner, the radial expansion process using the assembly 300 provides a telescoping of the radially expanded 15 tubulars into the wellbore 1000.

The assembly 300 may be operated to form a wellbore casing by including or excluding the float valve 354.

The float valve 354 may be operated in an auto-fill configuration in which tabs are positioned between the float valve 354 and the valve seat 352. In this 20 manner, fluidic materials within the wellbore 1000 may flow into the assembly 300 from below thereby decreasing surge pressures during placement of the assembly 300 within the wellbore 1000. Furthermore, pumping fluidic materials through the assembly 300 at rate of about 1.2 to 2m³/min (6 to 8 bbl/min) will displace the tabs from the valve seat 352 and thereby allow the float valve 354 to close.

25 Prior to the placement of any of the plugs, 1010 and 1016, into the assembly 300, fluidic materials can be circulated through the assembly 300 and into the wellbore 1000.

Once the bottom plug 1010 has been positioned into the assembly 300, 30 fluidic materials can only be circulated through the assembly 300 and into the wellbore 1000 if the sliding sleeve 342 is in the down position.

Once the sliding sleeve 342 is positioned in the down position, the passage 330a and rupture disc 336 are fluidically isolated from pressurized fluids within the assembly 300.

Once the top plug 1016 has been positioned into the assembly 300, no fluidic
5 materials can be circulated through the assembly 300 and into the wellbore 1000.

The assembly 300 may be operated to form or repair a wellbore casing, a pipeline, or a structural support.

Although this detailed description has shown and described illustrative embodiments of the invention, this description contemplates a wide range of
10 modifications, changes, and substitutions within the scope of the claims. In some instances, one may employ some features without a corresponding use of the other features and accordingly, it is appropriate that readers should construe the appended claims broadly .

CLAIMS

1. An apparatus for forming a wellbore casing in a borehole in a subterranean formation, comprising:
 - 5 means for radially expanding and plastically deforming an expandable tubular member; and
 - means for injecting a hardenable fluidic sealing material into an annulus between the expandable tubular member and the borehole;
 - wherein the means for injecting a hardenable fluidic sealing material into an
 - 10 annulus between the expandable tubular member and the borehole, comprises a sliding sleeve valve.
 2. An apparatus for coupling an expandable tubular member to a preexisting structure, comprising:
 - 15 means for radially expanding and plastically deforming the expandable tubular member within the preexisting structure; and
 - means for injecting a hardenable fluidic sealing material into an annulus between the expandable tubular member and the preexisting structure;
 - wherein the means for injecting a hardenable fluidic sealing material into an
 - 20 annulus between the expandable tubular member and the preexisting structure, comprises a sliding sleeve valve.

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